

Date: Thursday, 4/12/2007 9:13:19 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU:DAR001 Dart Helicopters Services Drawing Name : SPACEPOD ASSEMBLY LH/ DSI 9335  
 Job Number : 31766  
 Estimate Number : 10800  
 P.O. Number : *N/A* Part Number : D350600141  
 This Issue : 4/12/2007 S.O. No. : *N/A* Drawing Number : D3188,ICA  
 Prsht Rev. : NC Project Number : *N/A*  
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : *8E/2*  
 Previous Run : 31047 Material : *N/A*  
 Due Date : 4/30/2007 Qty: 1 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature] 07.04.13*  
 Comment : Est Rev: D 05.04.14 Incorporated procedures from D3187-1/-2 K  
 J/JLM  
 Est Rev: E 06-11-20 As per DSI9335 JLM  
 est rev F 07.02.07 iin rev.c ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG003

2.0 31766A SWITCH RELOCATION KIT



Comment: Sub-Component SWITCH RELOCATION KIT

*31766A*

3.0 31766B SPACEPOD BODY LH



Comment: Sub-Component SPACEPOD BODY LH

D3188-1M Batch: *B 31766 B**ml 07/06/07*

4.0 31766C SPACEPOD DOOR LH



Comment: Sub-Component SPACEPOD DOOR LH

D3186-1 B *31766 C**ml 07/06/07*

5.0 D31871 Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-1 Floor *825404*1 D3186-1 Door (ref) *B 31766 C (w/o 30010)*1 D3188-1 Body (ref) *B 31766 B (w/o 30020)*

✓

*ml 07/06/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

ALS41032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

28 ALS4-1032-130

Insert

M103475

X28

07/06/07

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1 into D3188-1.

2-Open holes in D3188-1 body floor to Ø0.297".

3-Install inserts in D3188-1 as per Dwg D3188.

4-Open holes in D3187-1 aluminum floor to 0.250" per dwg D3187

5-Deburr holes in D3187-1

ml 07/06/08

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/08

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

\*\*\*\*\*D3187-1 floor only\*\*\*\*\*

Chemical Conversion Coat as per QSI 005 4.1

ml

07-06-08

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

\*\*\*\*\*D3187-1 floor only\*\*\*\*\*

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

BR / EJ 07-06-12

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml

0706/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31766

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07/06/18

13.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)

Pick:

Qty Part Number

Description

Batch

5.62SF D2986

Neoprene Foam

B30632

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch:

M100565

PTO

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EB 07/06/18 ①

16.0

AL644032130

Insert



Washer A 3235-020-935



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Insert

batch:

B M9037 X2  
M104760 X6

VE 07.0620

17.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch:

B31127

18.0

MS20426AD45

Rivet



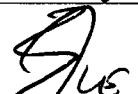

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Batch:

M13459

07/06/18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/06/20	160	Make change to the 8x A3235-020-935 washer. Remove insert.	E	07.06.21		 07.06.20 07.06.20 Per PS1042	 07.06.20	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/18	14	Bad installation of the foam. Foam folded over, i. banded.	<i>[Signature]</i> 07/06/18	took out the foam scrap it, buff smooth floor re-do the installation with new foam.	<i>[Signature]</i> 07/06/18	SB 07/06/18	<i>[Signature]</i> 07/06/18	<i>[Signature]</i> 07/06/18

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Job Number: 31766

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35491

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch:

B31125

20.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Batch:

B31692

21.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch:

B30210

22.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Batch:

M103641

23.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Batch:

B30169

24.0

MS20426AD46

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rivet

Batch:

M2566

25.0

D35381

HINGE BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch:

B32371

*Handwritten signature and date: 4/12/06/07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31766

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: B30630

✓

27.0

AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M9216

✓

28.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M104093

✓

29.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: M104118

✓

30.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3187-1 floor with D3188-1 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for body & floor\*\*\*\*

N/A

Step Ref. only  
ml07/06/08

31.0

D35529

CARBON STEEL GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: B30673

✓

32.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M103555

CP 7/16/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31766

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M104093



34.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: M100993



35.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M104118



36.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: B30681



37.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: B31127



38.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Door Latch

batch: B30880



39.0

D2585

Latch Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Latch Clamp

batch: B28019

*Handwritten signature and date: 4/10/06 1070*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31766

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

D2621

Latch Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Latch Plate

batch: B31111

41.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Screw

batch: M15432

42.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

batch: M104118

43.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

batch: M103691

44.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B30885

45.0

D2228

Backing Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Backing Plate

batch: B30679

46.0

AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M103585

*Signature*  
4/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Thursday, 4/12/2007 9:13:20 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31766

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

AN960JD8

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: M104093

48.0

MS21042L08

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: M104118

49.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: B30718

50.0

D35481

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: B30245

51.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~1.0000~~ Each(s)

BALL STUD

batch: B30210

52.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~1.0000~~ Each(s)

Washer

batch: M103641

53.0

D30153

Lock Nut.



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~1.0000~~ Each(s)

Lock Nut

batch: B30169

*CPA 7/16/07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31766

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

54.A



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-1 door with D3188-1 body as per Dwg ICA-D350-600

\*\*\*Hardware on previous steps is for door ass'y\*\*\*\*

ml 07/06/19 x1

55.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

56.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

54.B



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: m109281

FR 07/06/20 ①

57.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

54.C



Comment: Inspect Wing Walk

58.0

K10018

Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 K10018

Spacepod Hardware Kit

B32425

1 D3187-1(Ref)

Spacepod Floor

B25407

07/06/20 ②

59.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

60.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-147

Location:

PPP Rev:

07/06/20 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 2 Date: 07/06/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:13:21 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31766

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FD0706121

Job Completion



FD0706121

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

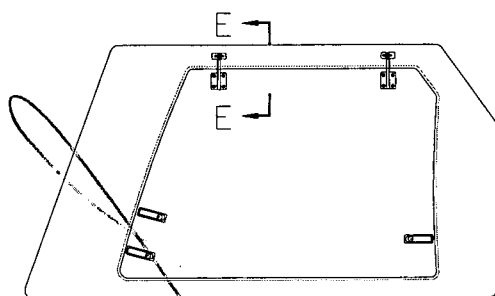


FIGURE 3. LOOKING AT OUTSIDE OF  
D350-600-145 DOOR  
(D350-600-146 SIMILAR AND OPPOSITE)

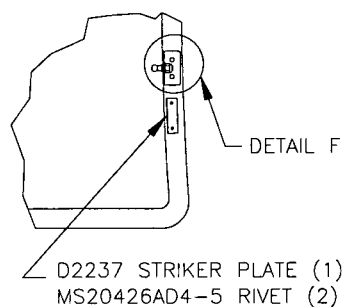


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

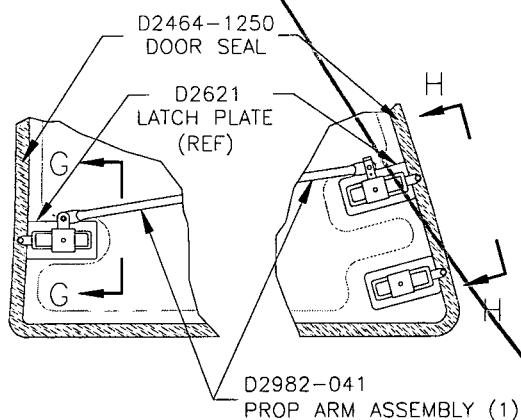
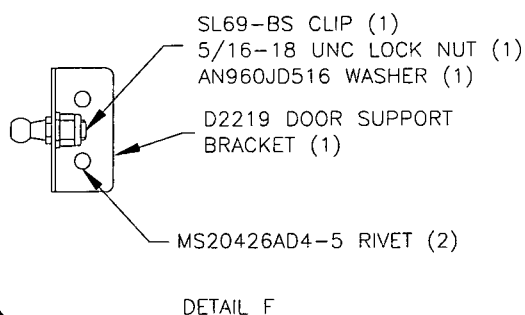


FIGURE 5. LOOKING AT TYPICAL INSIDE  
OF D350-600-145/-146 DOOR



DETAIL F

TC Accepted

MAY 07 2003

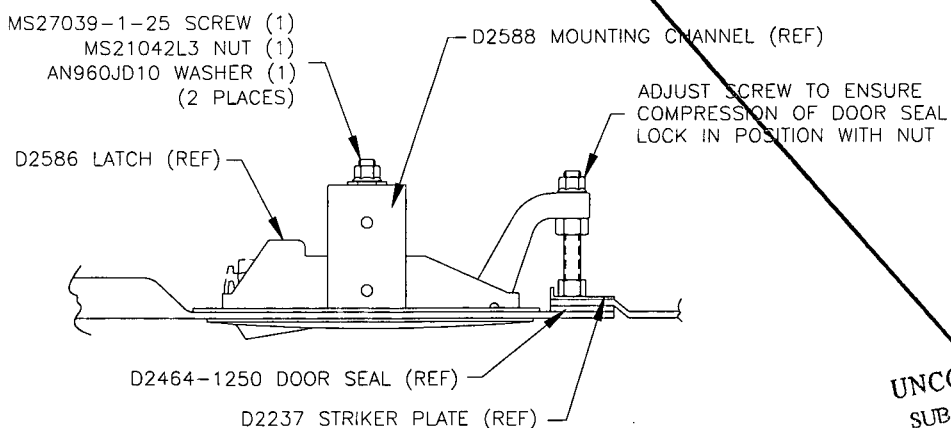
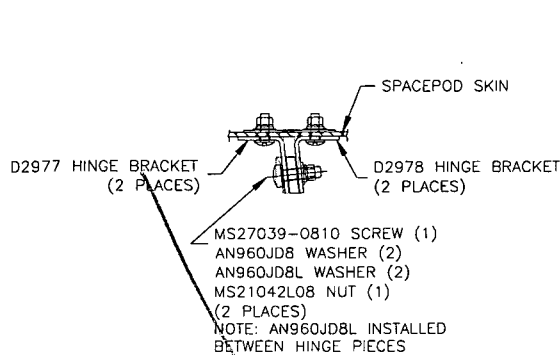


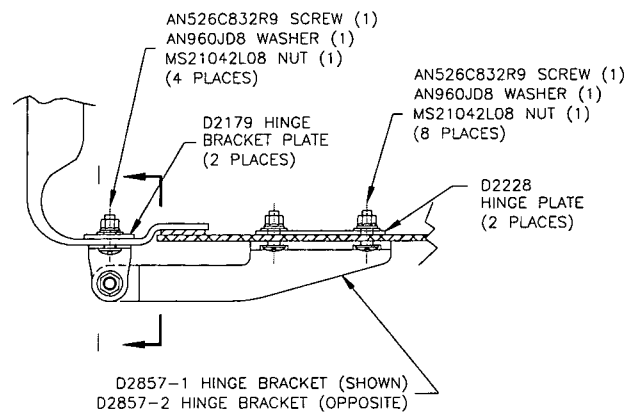
FIGURE-6.-TYPICAL LATCH INSTALLATION

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31766

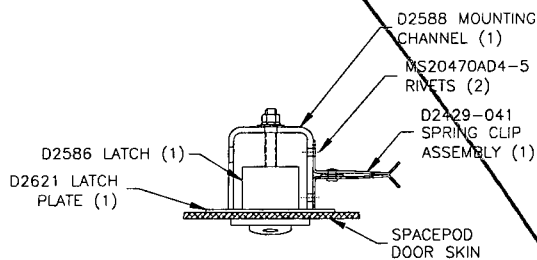
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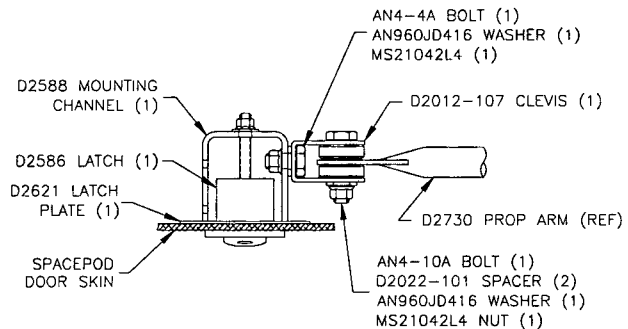
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

## 25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.

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TC Accepted

MAY 07 2003

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07.04.02

DESIGN	JB	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	[Signature]	REV. E
DATE	07.04.02	TITLE	D3188	SHEET 1 OF 11
		SPACEPOD BODY		SCALE
A	03.04.03	NEW ISSUE		NTS
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7		
C	06.12.13	REMOVED D0600-XXX LABELS		
D	07.02.22	UPDATE DIMENSIONS		
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11		

**GENERAL NOTES:**

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8500

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

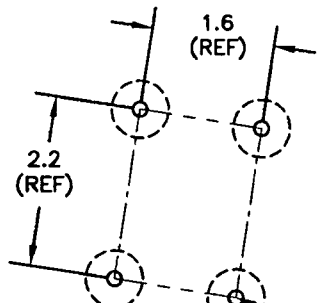
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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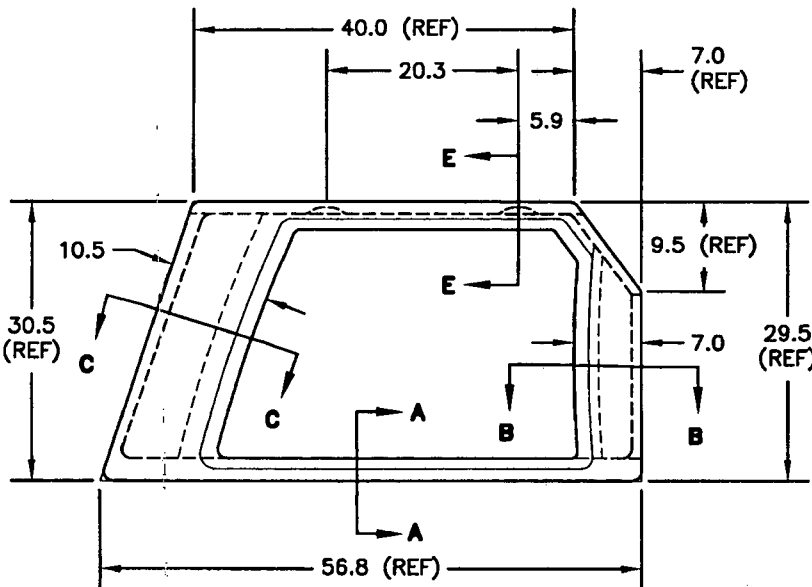
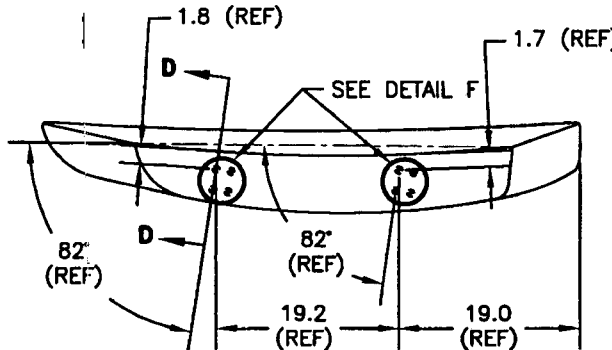
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DATE	07.04.02	TITLE	SPACEPOD BODY	REV. E SHEET 2 OF 11
		SCALE	NTS	

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07-04-01

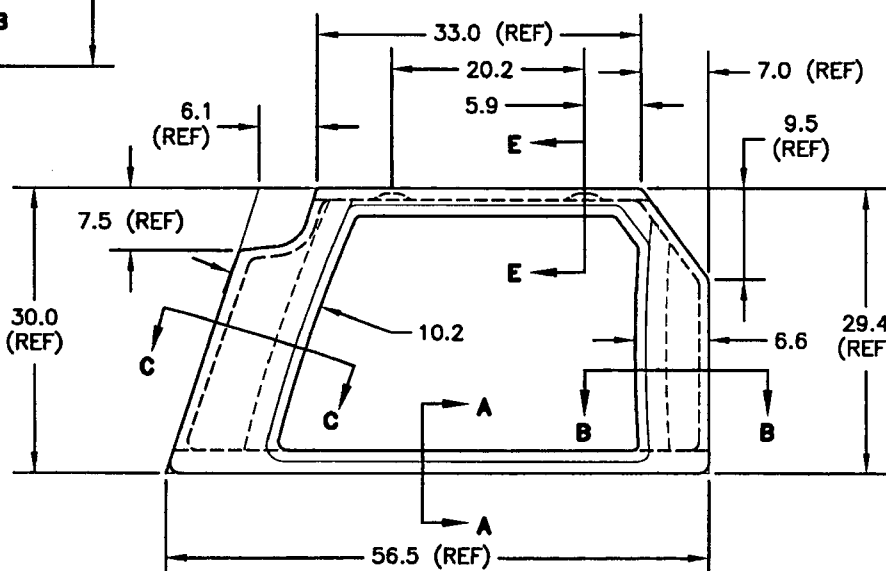
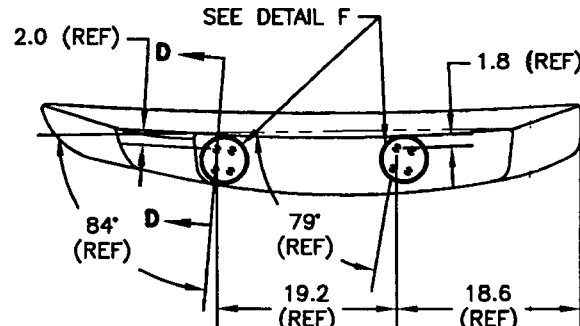


**DETAIL E**

INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**D3188-1M SPACEPOD BODY**



**D3188-3M SPACEPOD BODY**

**D3186-1M/-3M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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31260

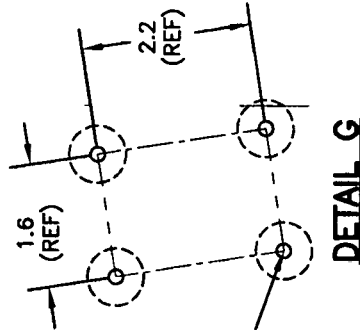


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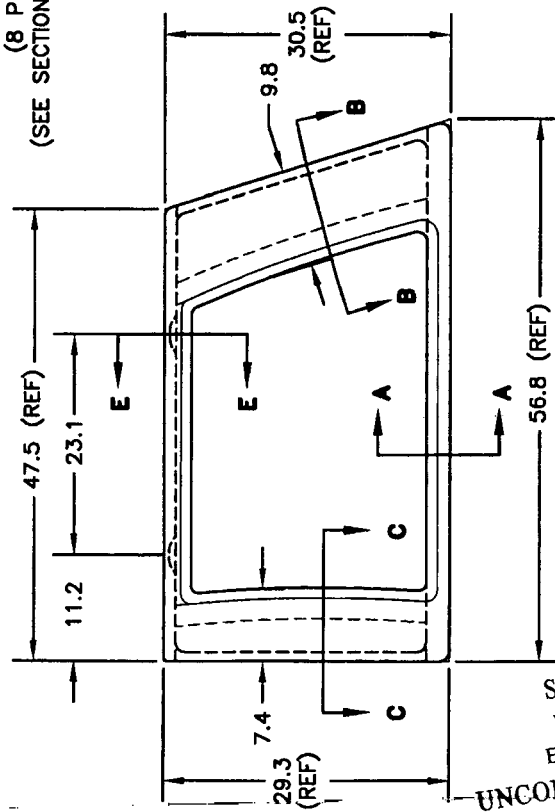
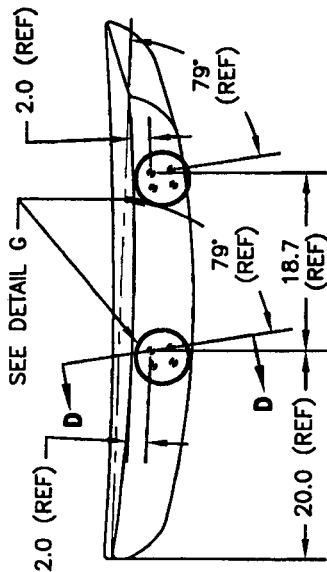
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CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3188</b>	REV. E SHEET 3 OF 11
DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS

RELEASED

07.04.02 **[Signature]**



INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**D3188-2M SPACEPOD BODY**

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D3188-2M NOTES:  
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.  
2) SEE SHEET #4 FOR SECTION VIEWS.

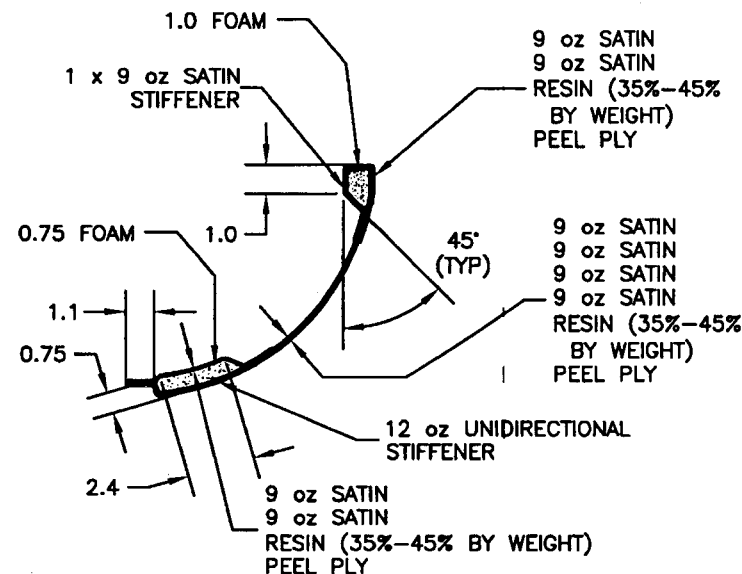
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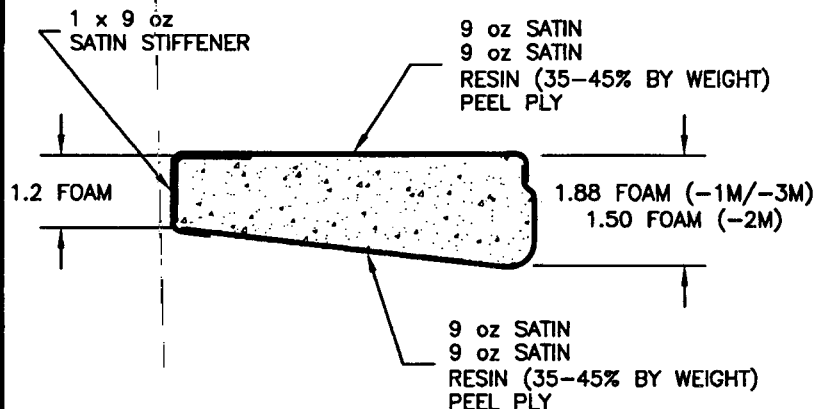
**DART**

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CHECKED	CE	APPROVED	[Signature]	DRAWING NO.	D3188
DATE	07.04.02	TITLE	SPACEPOD BODY	REV. E	SHEET 4 OF 11
		SCALE	NTS		

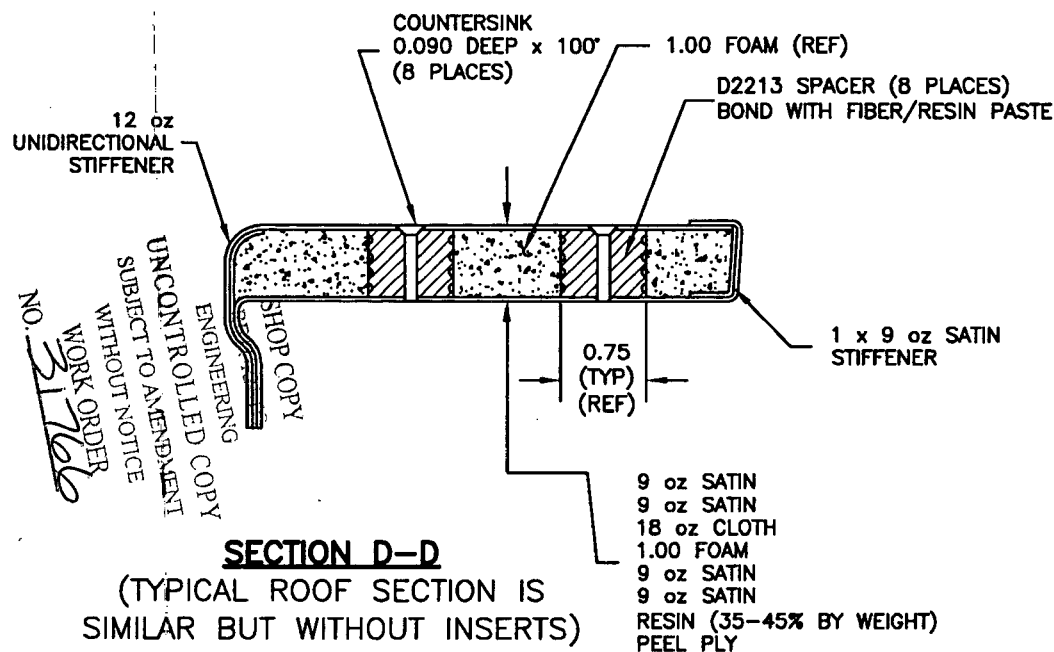
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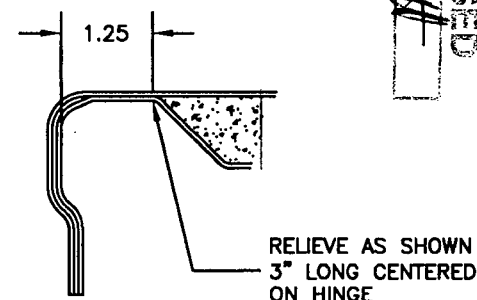
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)



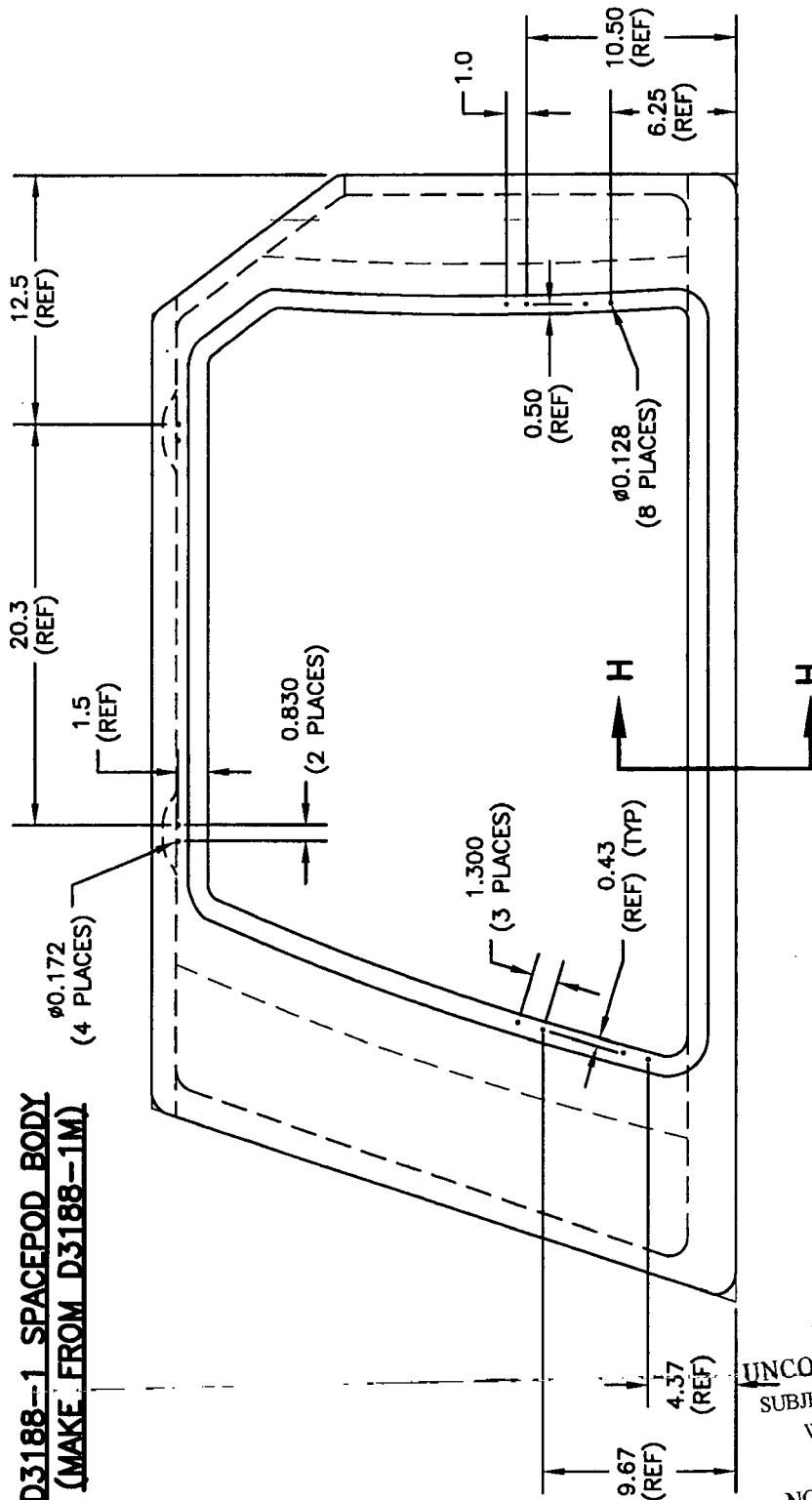
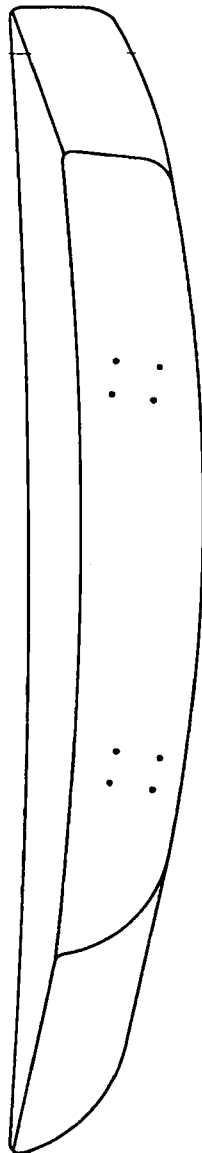
**SECTION E-E**  
(2 PLACES PER POD)

**DART**

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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS

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07.04.02



**D3188-1 SPACEPOD BODY**  
**(MAKE FROM D3188-1M)**

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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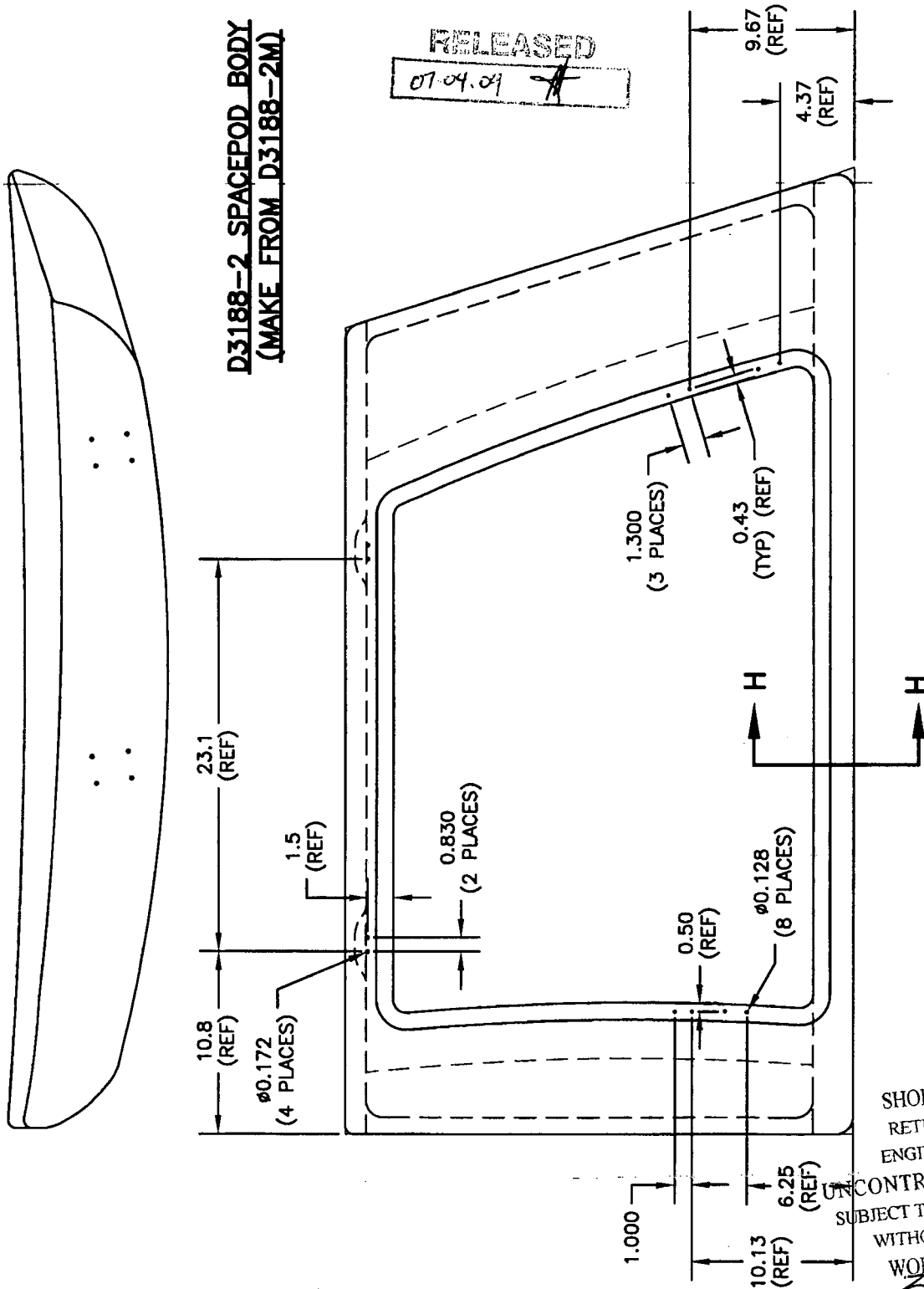
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEW

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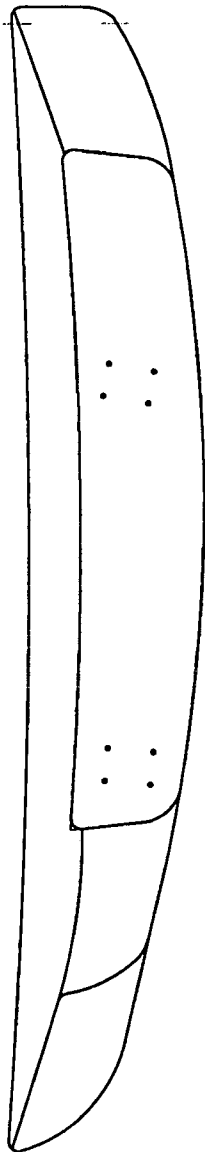
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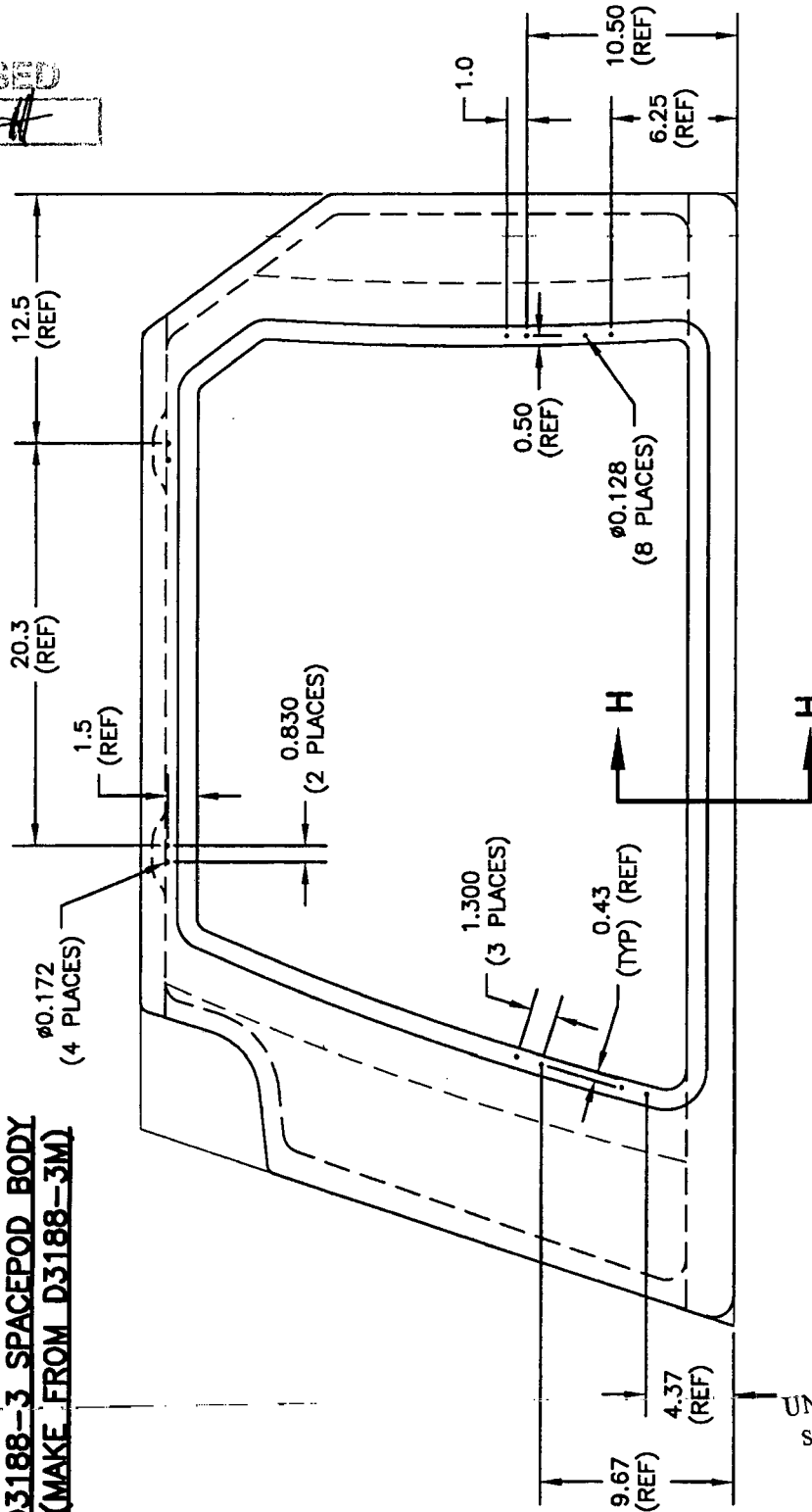
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.09 H



**D3188-3 SPACEPOD BODY  
(MAKE FROM D3188-3M)**

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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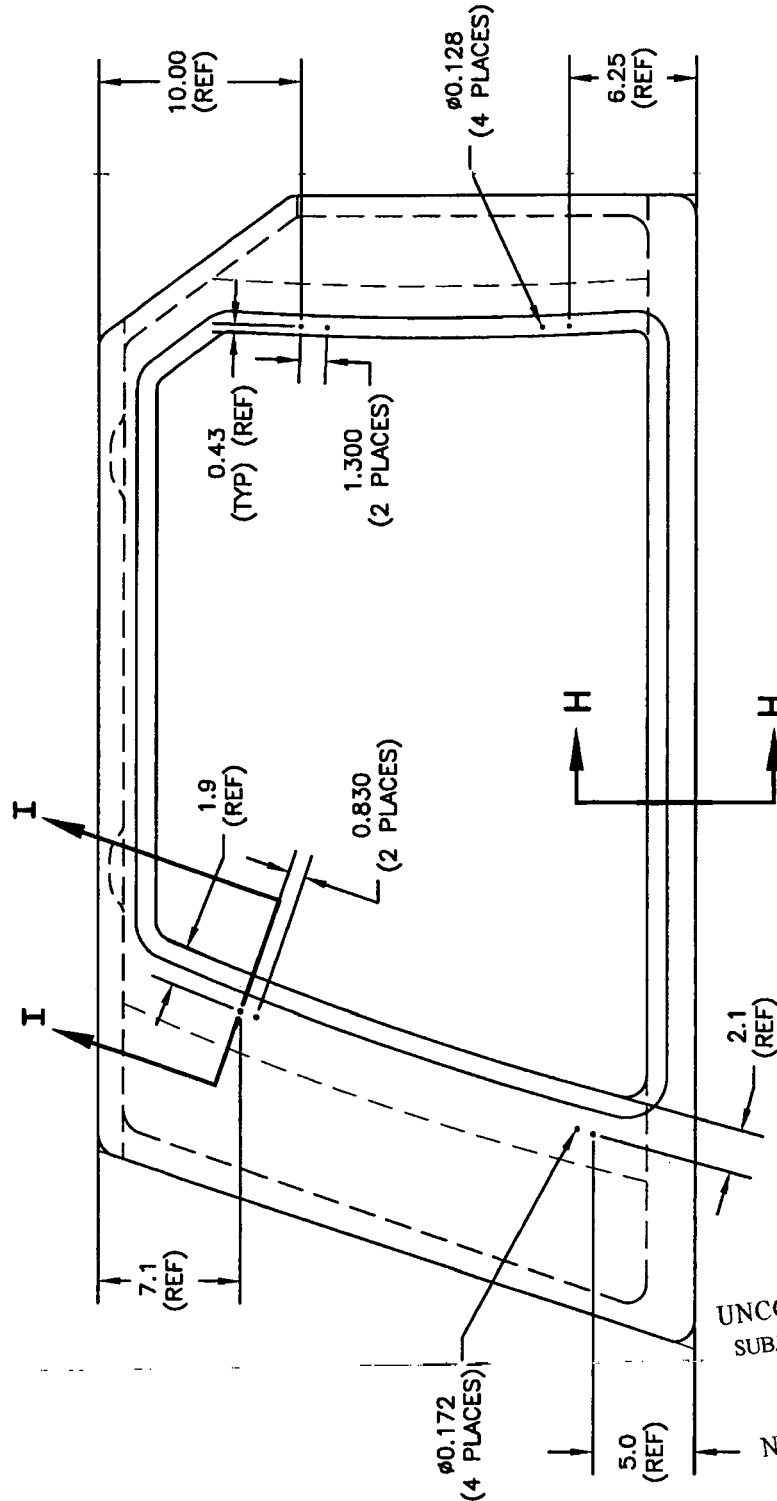
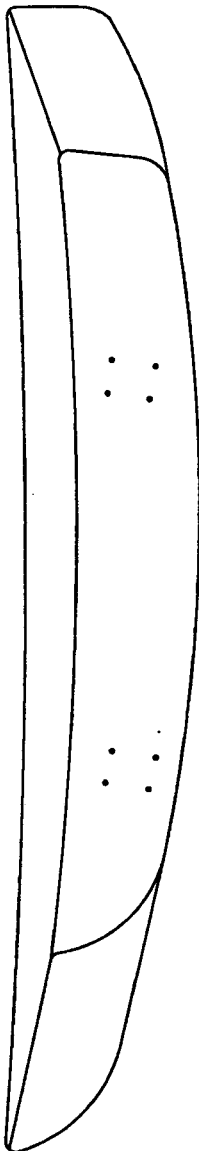
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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE <b>NTS</b>

RELEASED

07.04.02

**D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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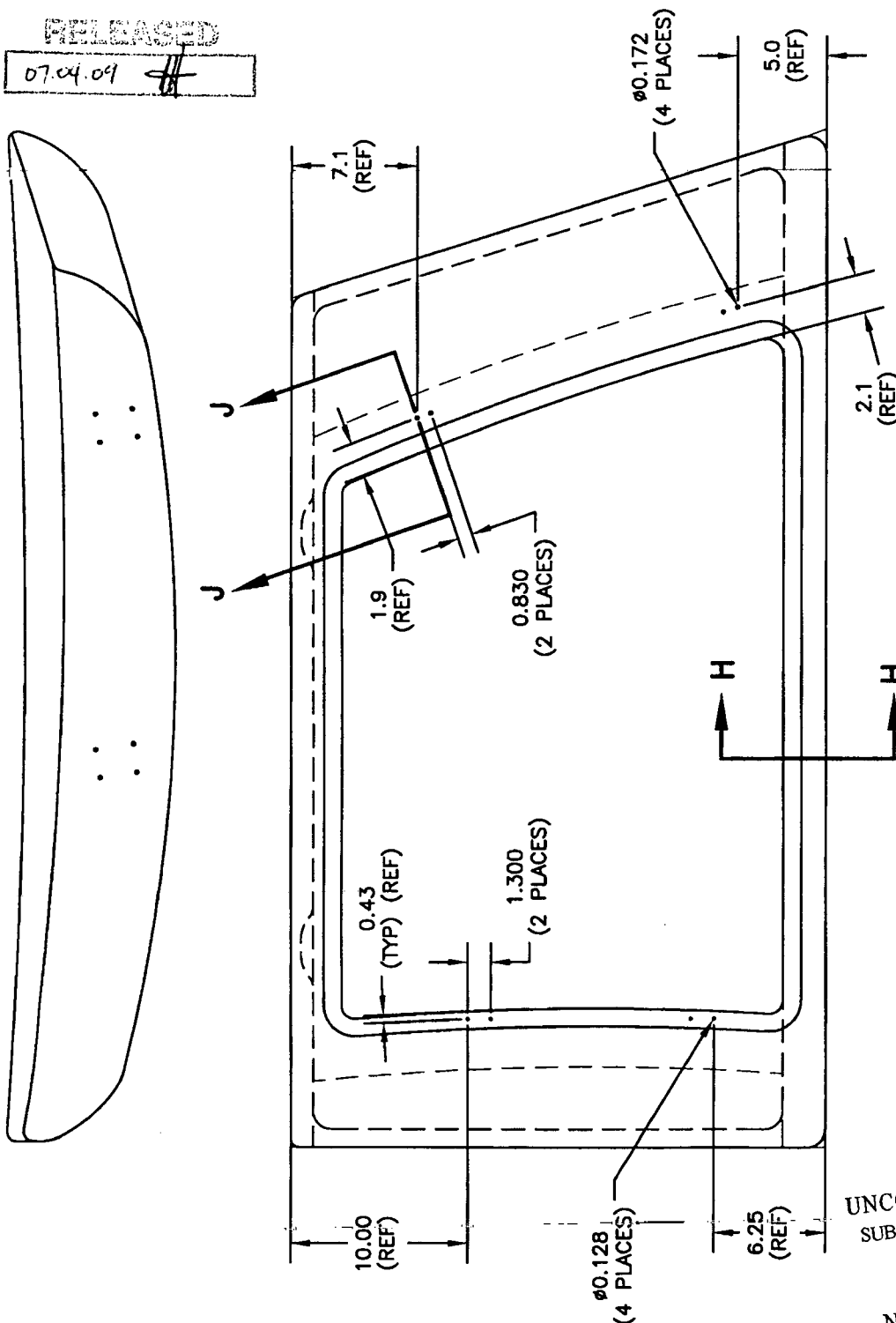
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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE <b>NTS</b>

RELEASED

07.04.09

**D3188-6 SPACEPOD BODY**  
**(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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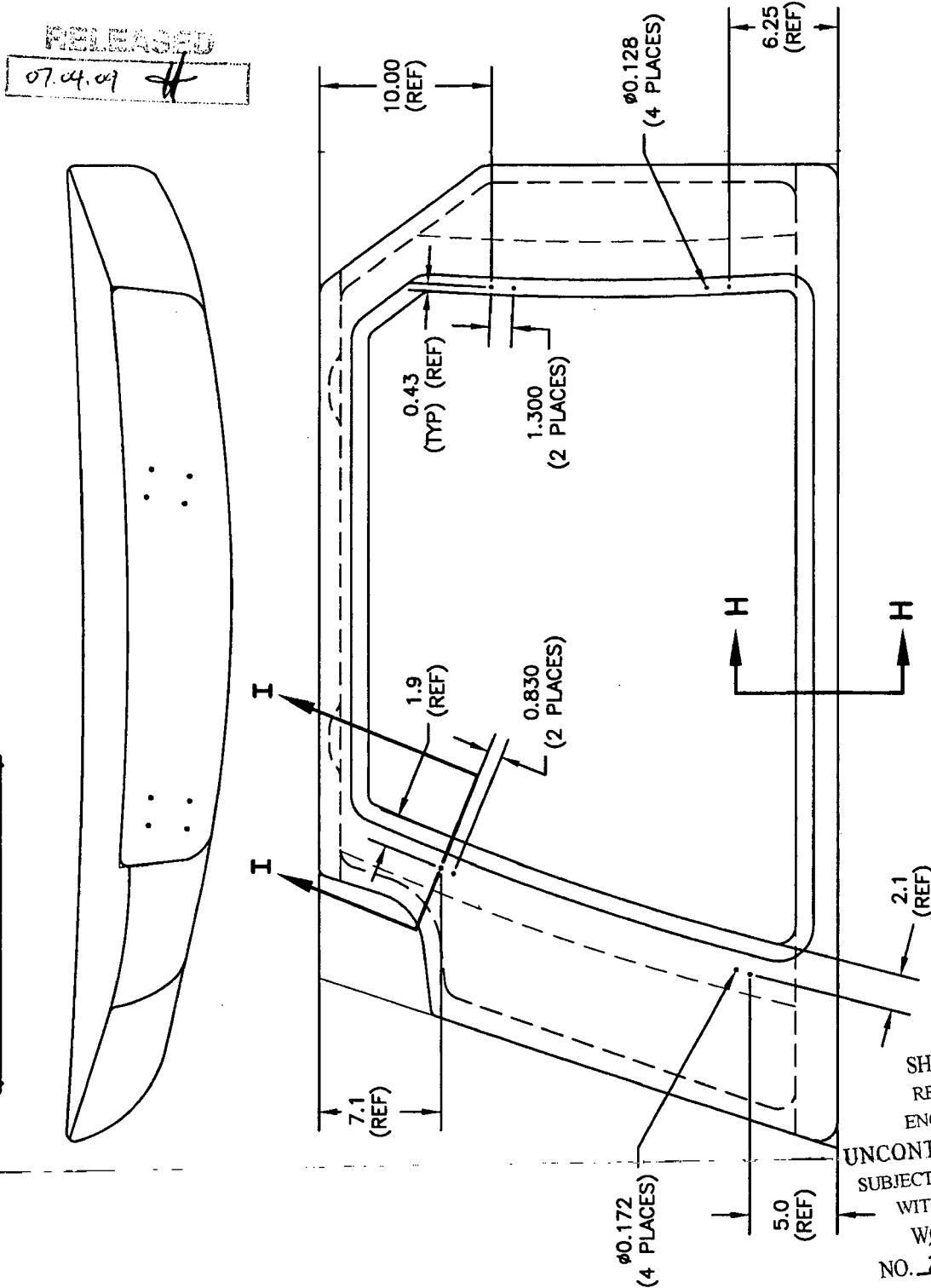
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

**D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



**NOTE:**  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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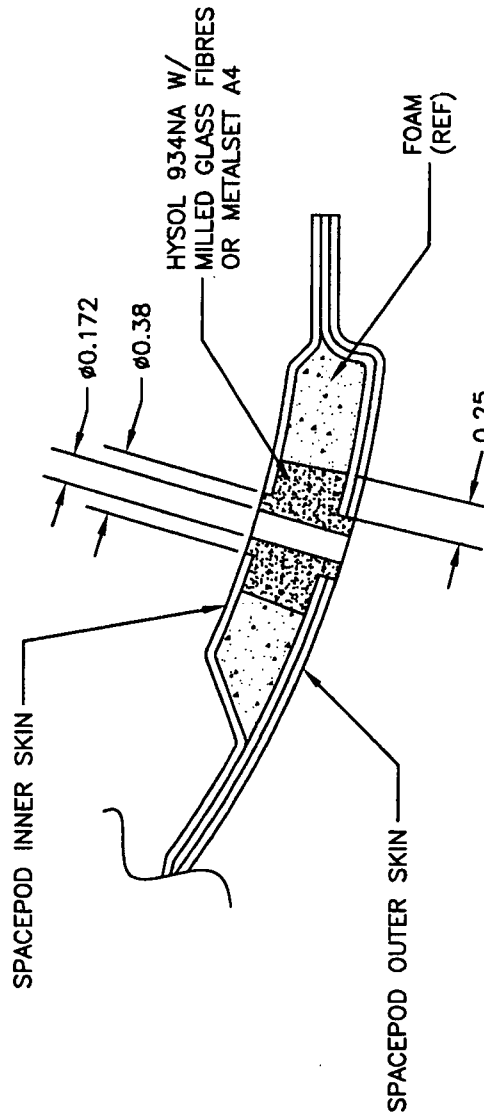
07.04.09 [Signature]

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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Date: Wednesday, 12/20/2006 1:44:52 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY LH
Job Number	: 30020		
Estimate Number	: 12595		
P.O. Number	: <i>N/A</i>	Part Number	: D31881M
This Issue	: 12/20/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3188 REV <i>BC</i> <i>LE</i> 07.01.18
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision	: <i>BC</i> <i>LE</i> 07.01.18
Previous Run	: 30019	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 1/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i> 06 12 20		
Comment	: Est Rev A New issue ecn882 06-11-30 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Ship To Delastek

8	D2213	Spacer	Batch: <i>B25325</i> <i>C207101102</i> <i>(2)</i>
---	-------	--------	---

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING  
 Issue P/O: *2767* *C206112121*  
 Description: D3188-1 BODY  
 Ship: D2213 Spacers  
 Supplier: Delastek  
 Conformity Certificate and Process sheet required  
 Ship 2 Items from Previous steps

3.0	D31881P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.  
*file to se* *[Signature]*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 1 Date: 07/06/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 12/20/2006 1:44:52 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 30020

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

*mul 07/06/07*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*mul 07/06/07*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Don 06/21*

Job Completion



*u 07-06-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. C
JB	CE	DRAWING NO.	D3188	SHEET 1 OF 11
CHECKED PH	APPROVED PH	TITLE	SPACEPOD BODY	SCALE N1S
DATE 06.12.13				
A	03.04.03	NEW ISSUE		
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7		
C	06.12.13	REMOVED D0600-XXX LABELS		

**GENERAL NOTES:**

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

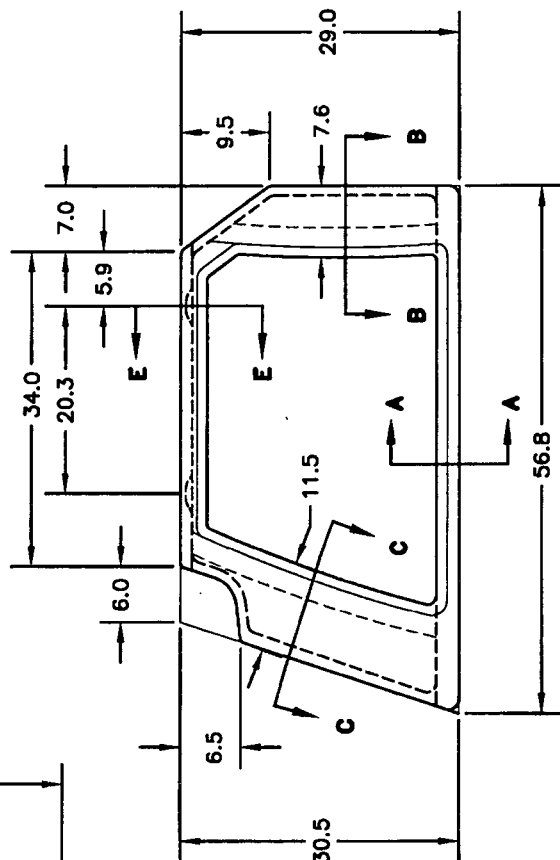
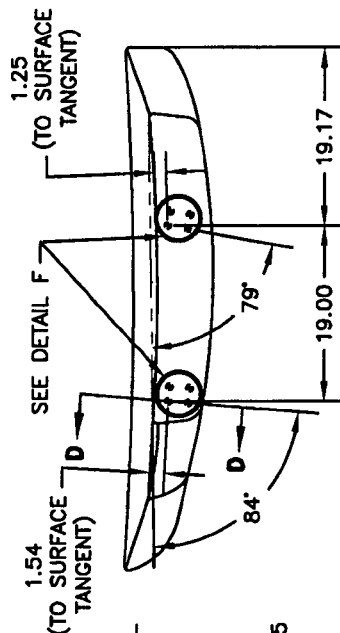
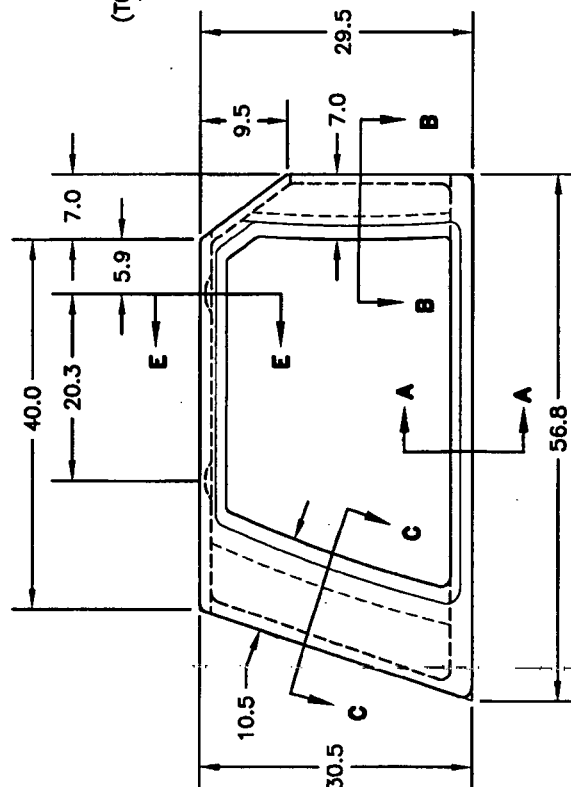
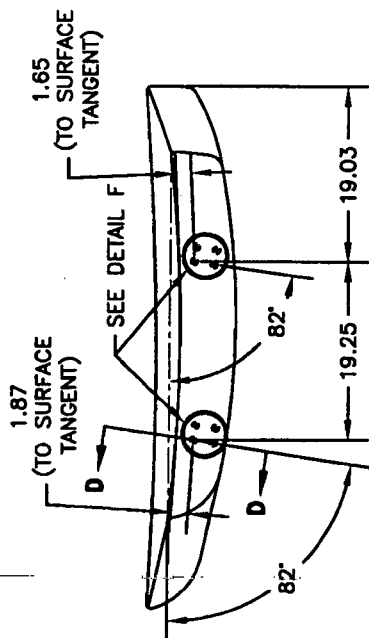
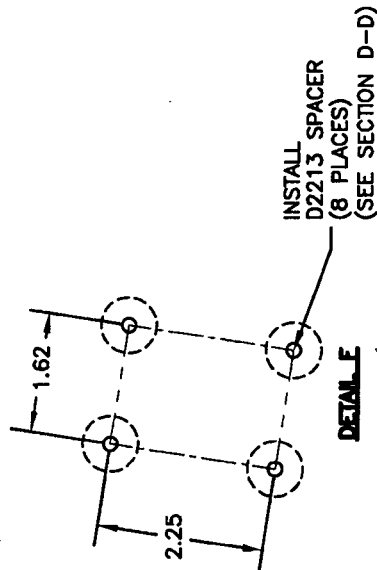
5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7. ALL DIMENSIONS ARE IN INCHES
8. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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06.12.22



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DATE <b>06.12.13</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS



D3188-1M SPACEPOD BODY

D3188-3M SPACEPOD BODY

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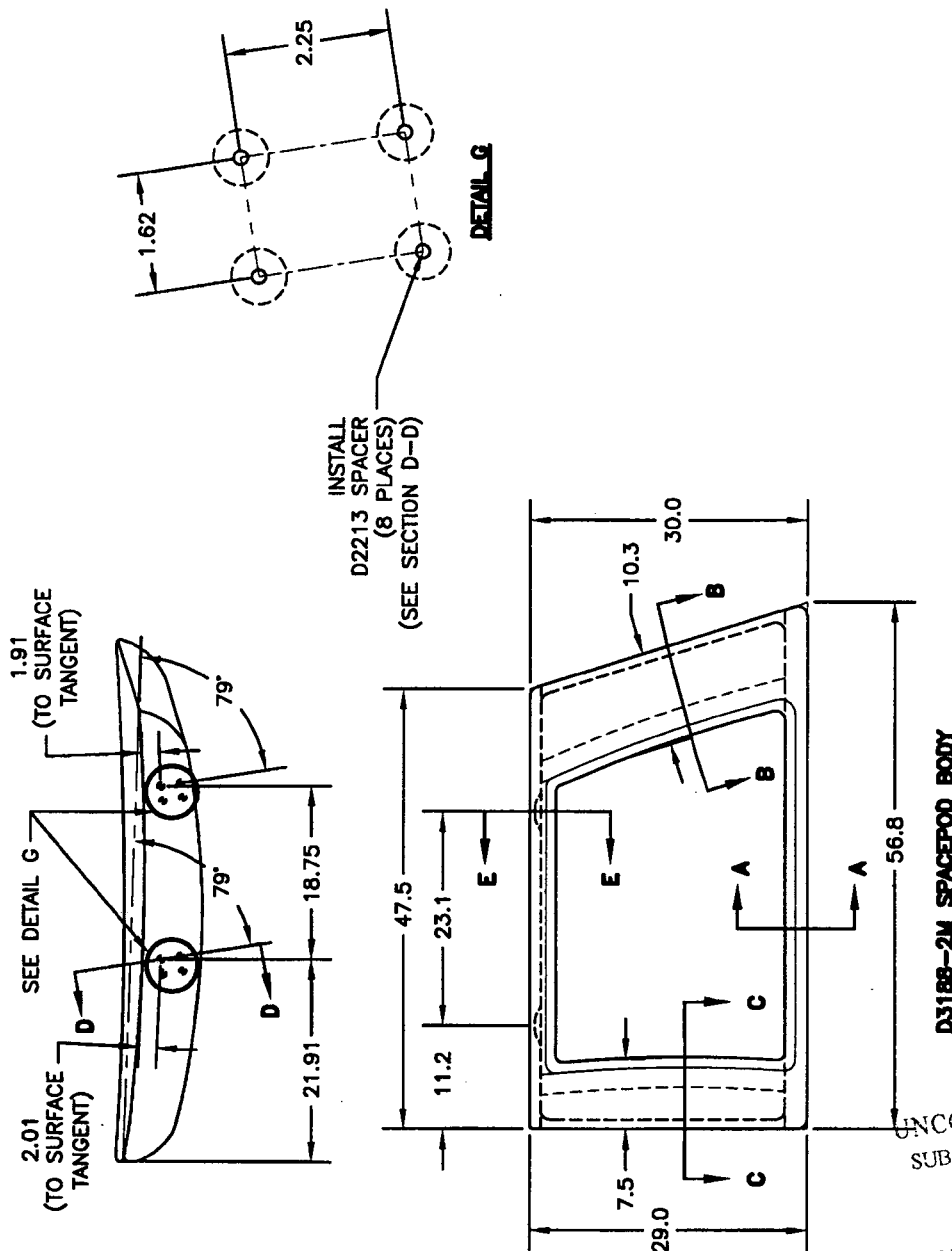
NOTE:  
SEE SHEET #4 FOR SECTION VIEWS

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DATE <b>06.12.13</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS



D3188-2M SPACEPOD BODY

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NO. 39070

RELEASED  
06.12.22

NOTE:  
SEE SHEET #4 FOR SECTION VIEWS

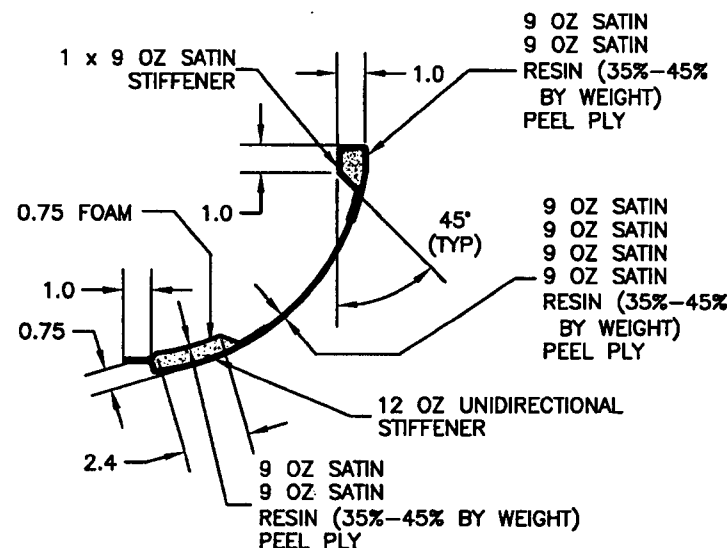
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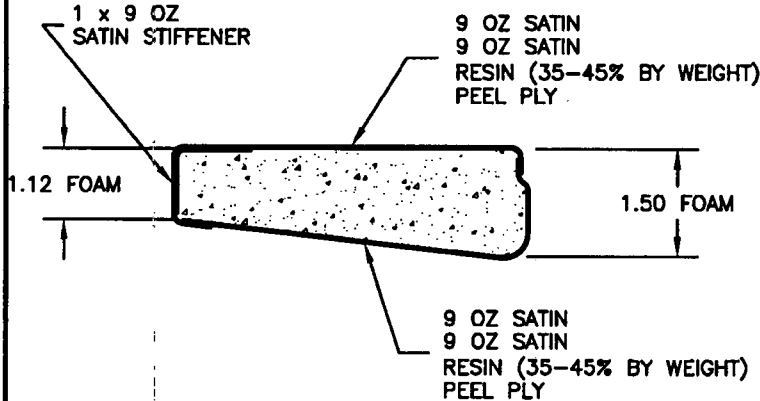


**DART**

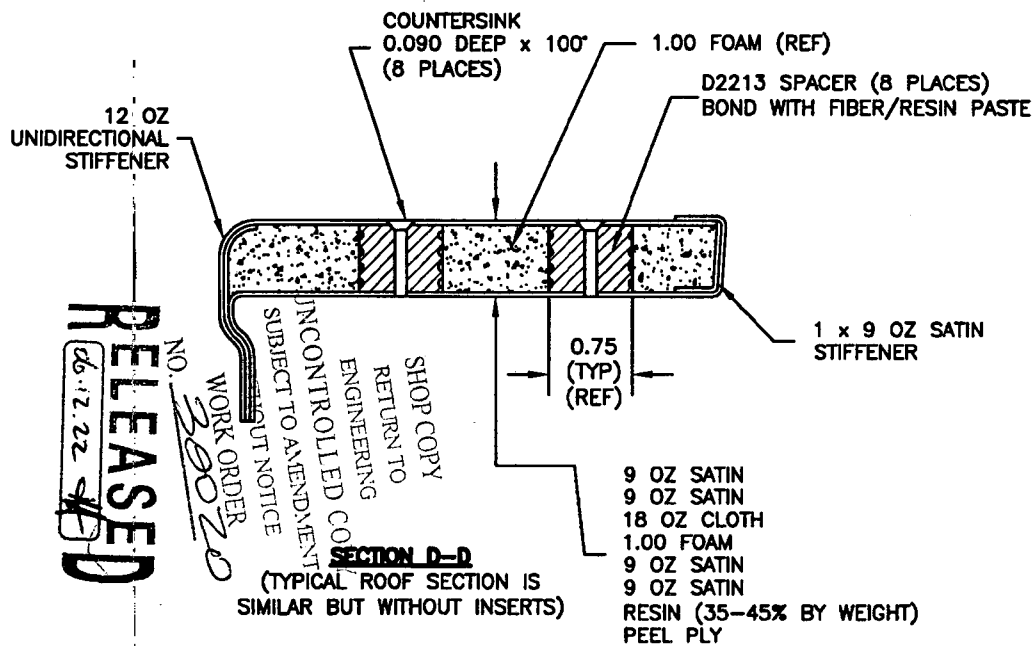
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CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.12.13	DRAWING NO.	D3188	REV. C
		TITLE	SPACEPOD BODY	SHEET 4 OF 11
		SCALE	NTS	



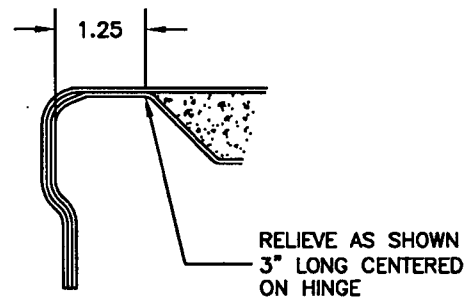
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)



**SECTION E-E**  
(2 PLACES PER POD)

**RELEASED**  
NO. 30020  
WORK ORDER  
06.12.22

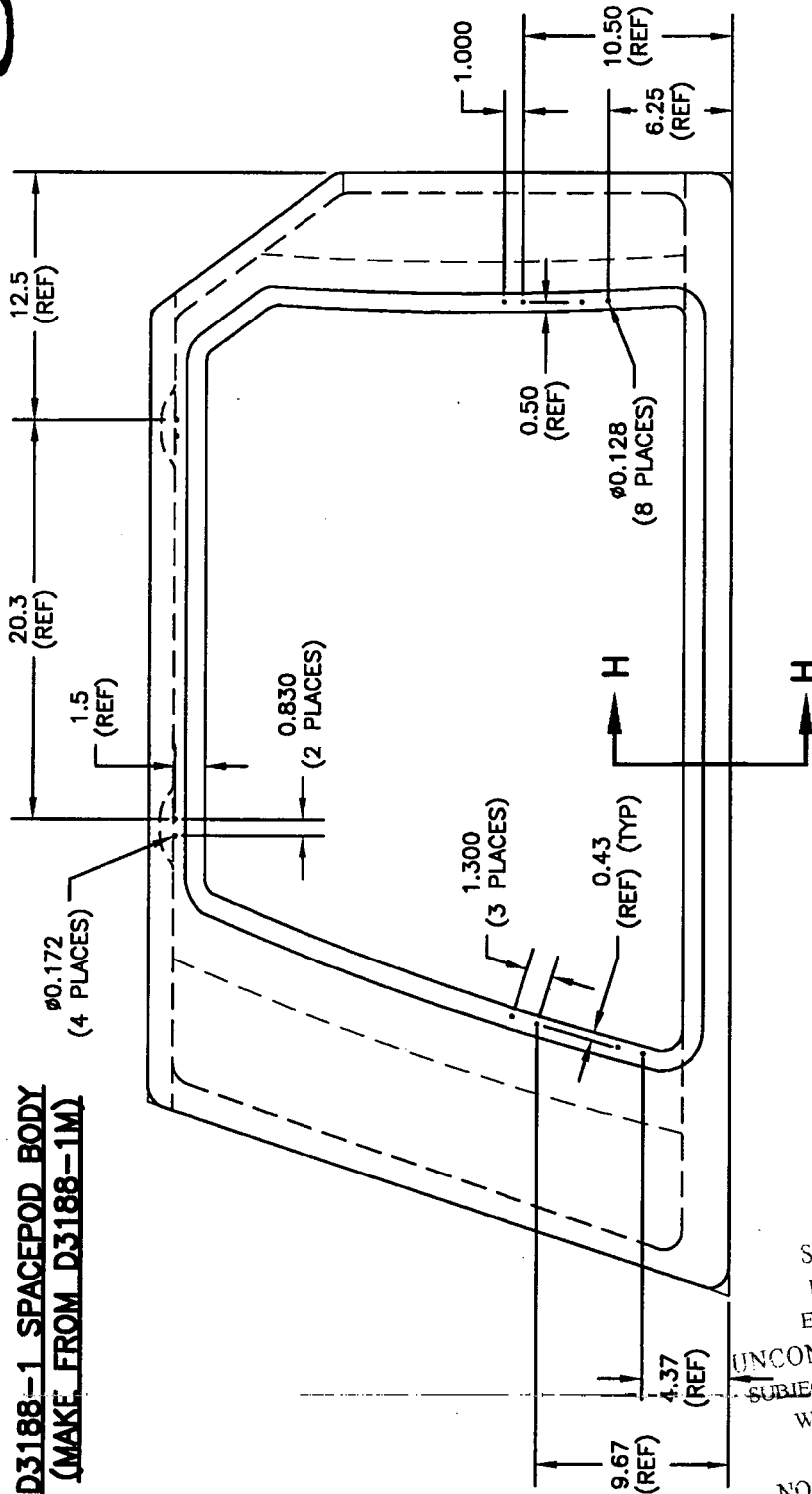
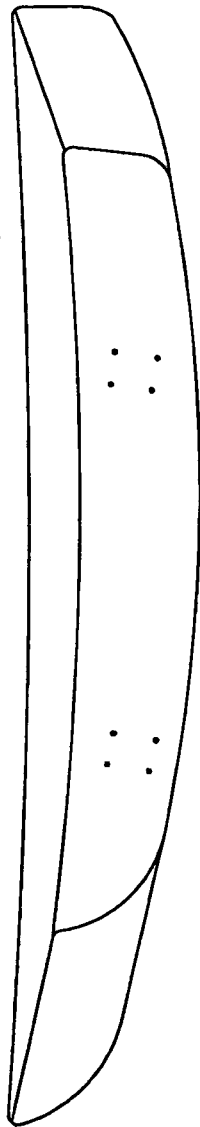
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22



D3188-1 SPACEPOD BODY  
(MAKE FROM D3188-1M)

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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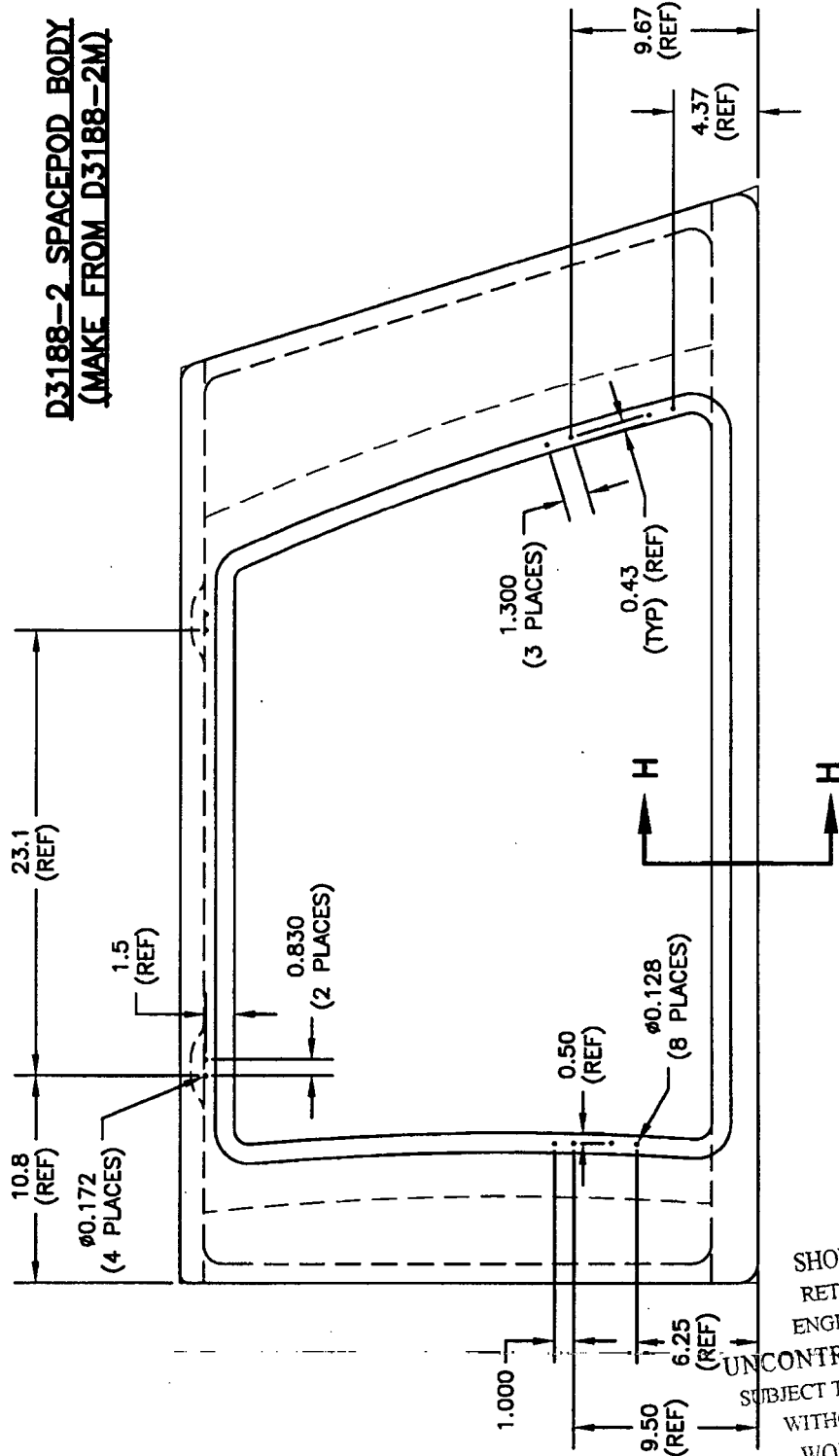
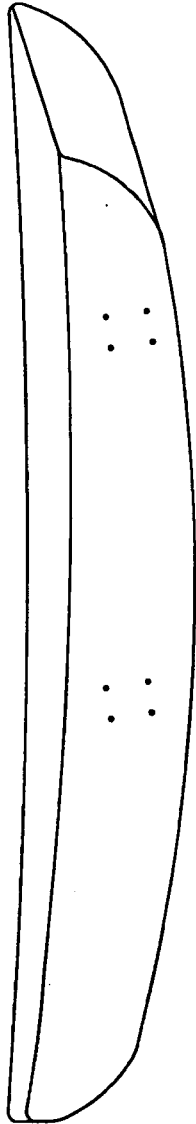
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
06.12.22

**D3188-2 SPACEPOD BODY  
(MAKE FROM D3188-2M)**



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEW

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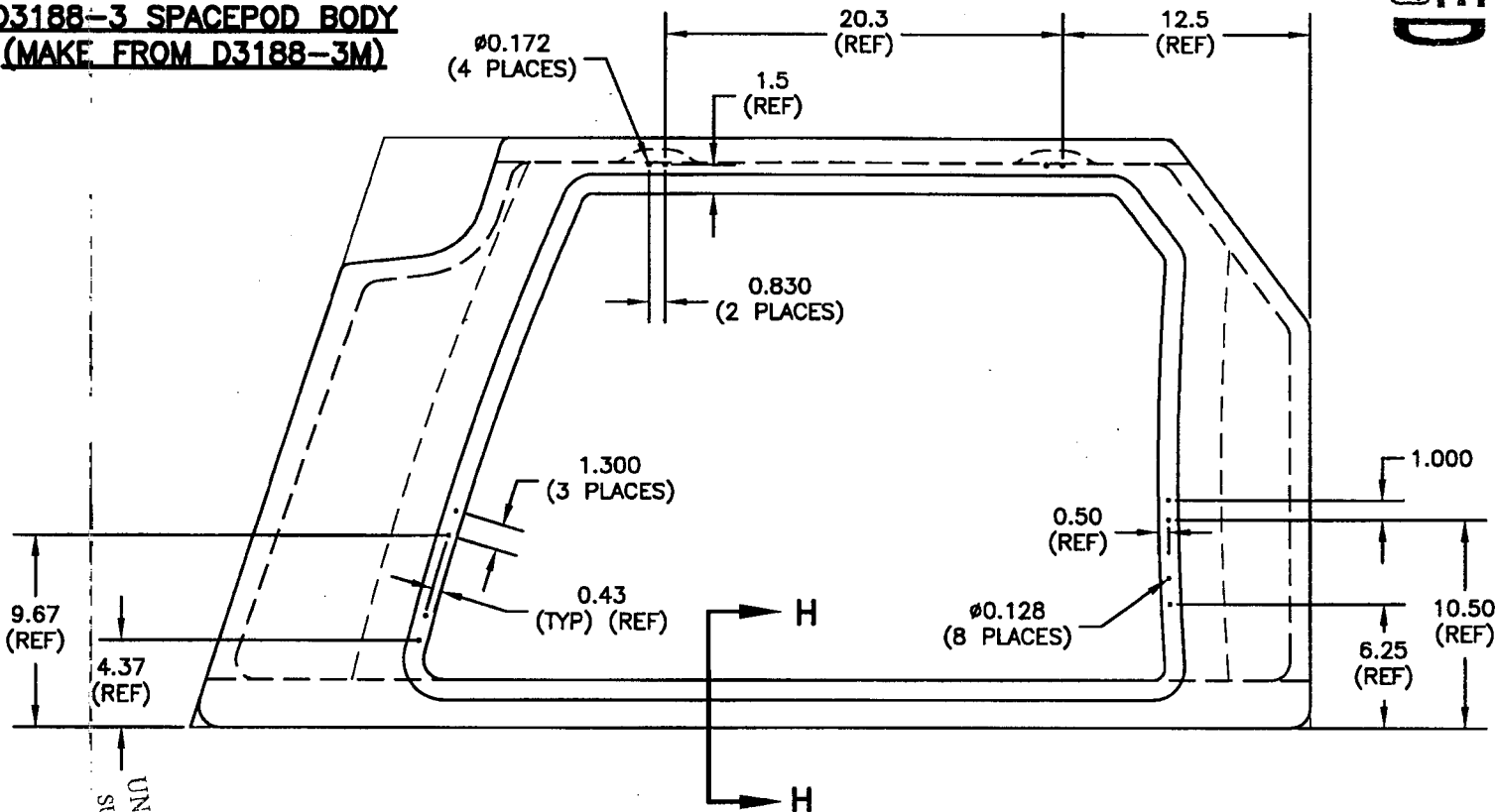
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DATE	06.12.13	DRAWING NO.	D3188
TITLE	SPACEPOD BODY	SHEET 7 OF 11	REV. C
SCALE	NIS		

**D3188-3 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

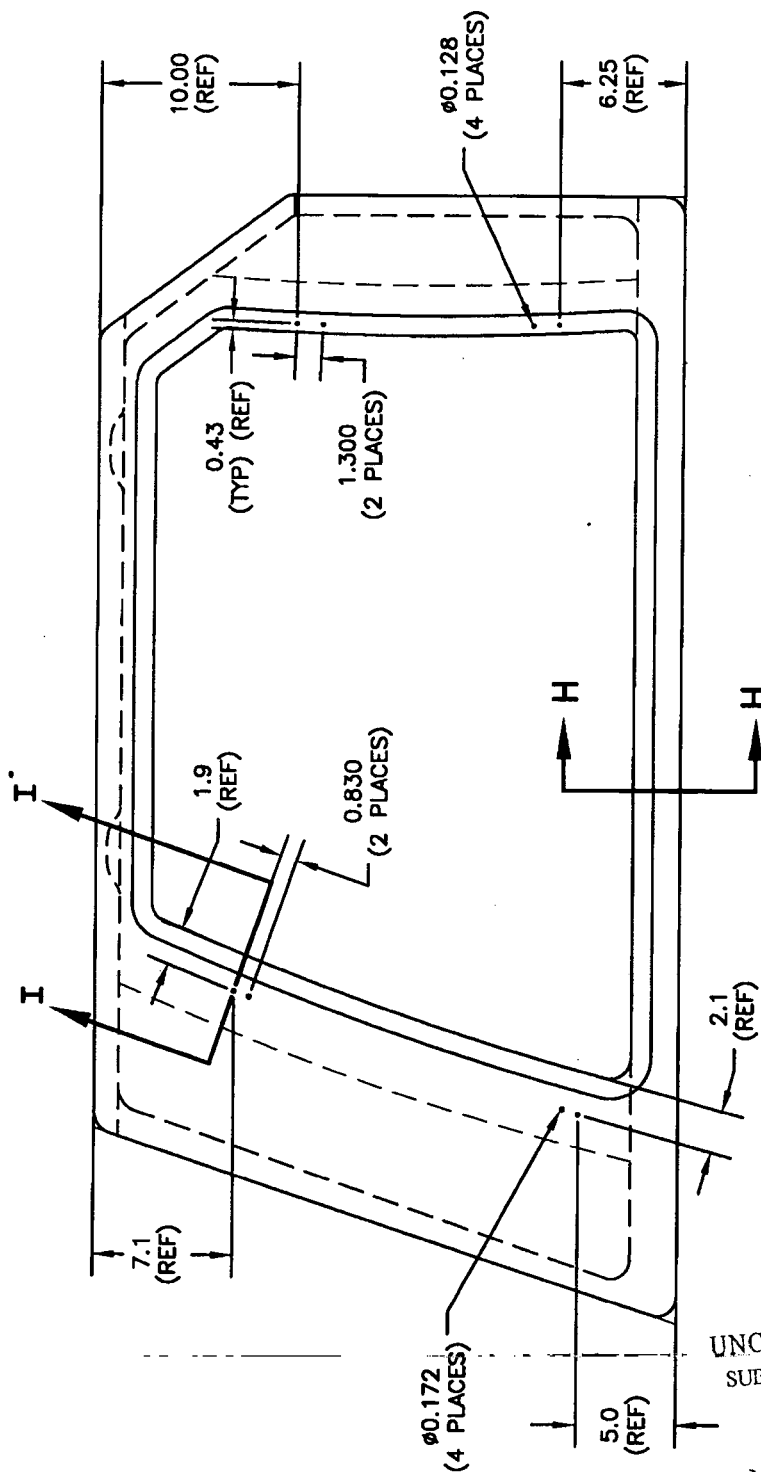
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
06.12.22 [Signature]

D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEWS

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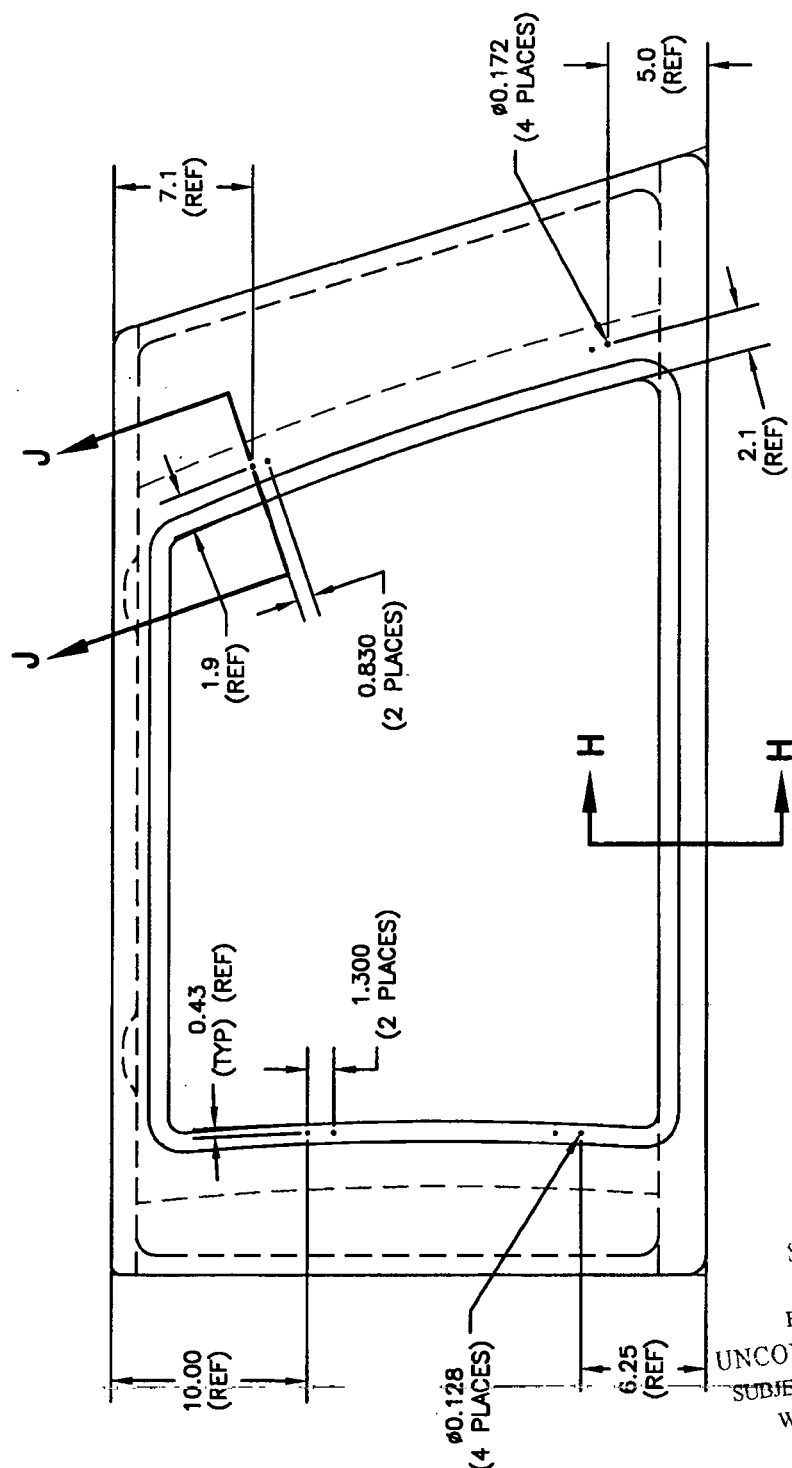
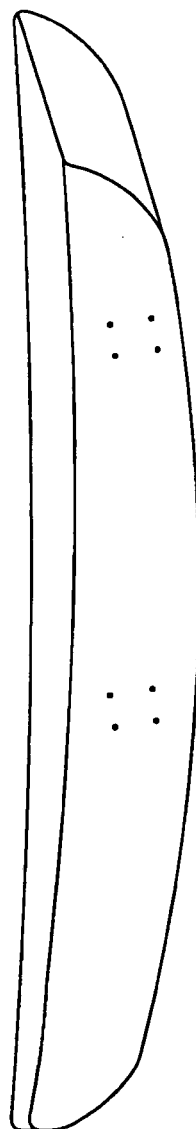
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
06.12.22 [Signature]

D3188-6 SPACEPOD BODY  
(MAKE FROM D3188-2M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEWS

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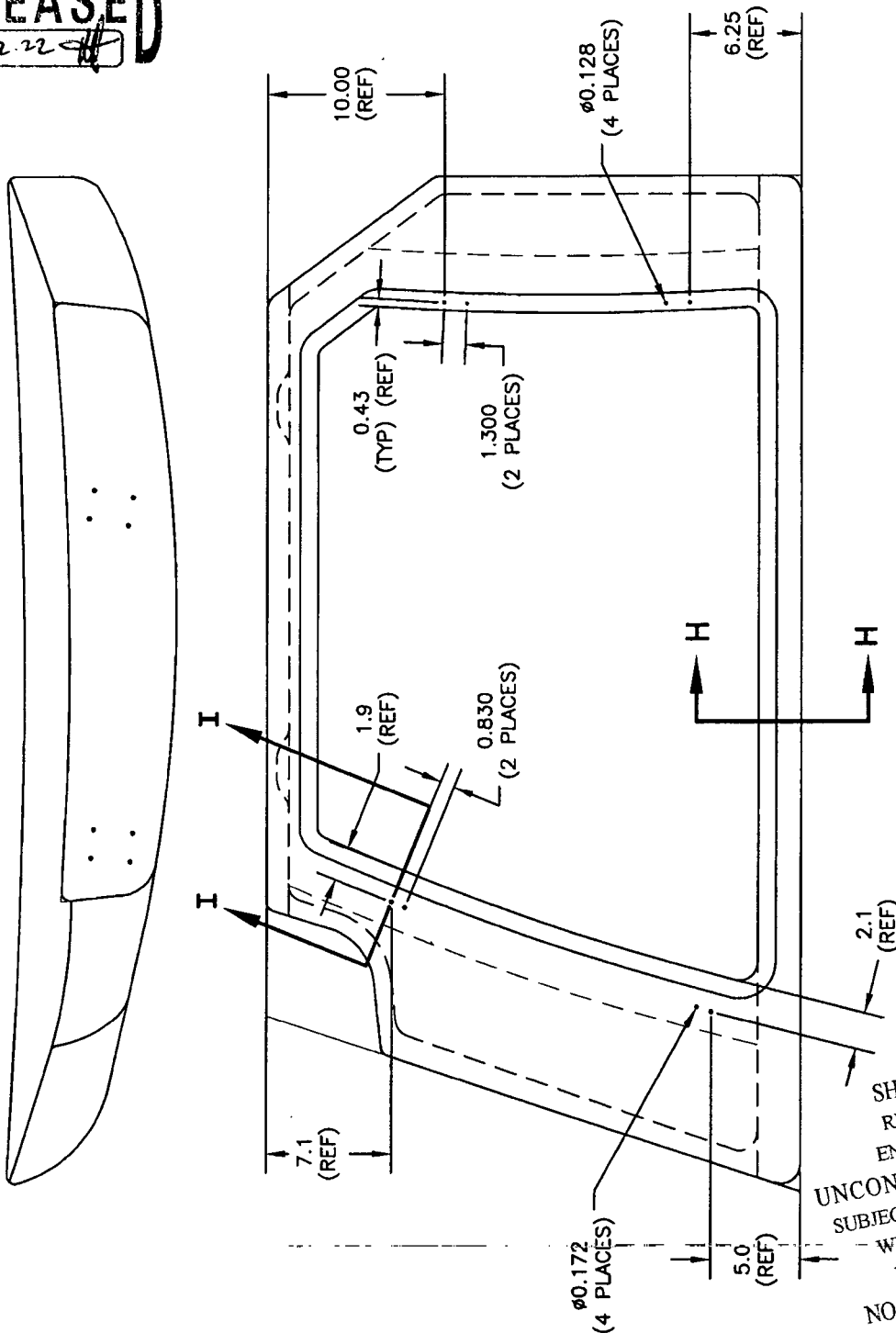
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED  
06.12.22

D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)



NOTE:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEWS

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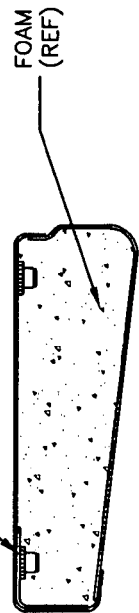
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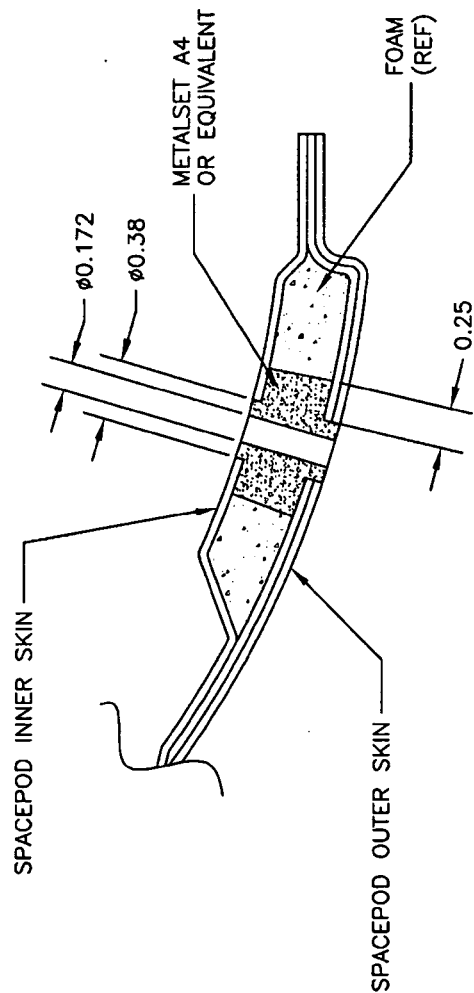
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DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS

RELEASED  
06.12.22

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)



SECTION H-H  
(TYPICAL FLOOR SECTION)



SECTION I-I  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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Date: Thursday, 4/12/2007 9:13:41 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD BODY LH
Job Number	: 31766B		
Estimate Number	: 12595		
P.O. Number	:	Part Number	: D31881M
This Issue	: 4/12/2007 S.O. No. :	Drawing Number	: D3188 REV <i>DE</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: <i>DE</i>
Previous Run	: 31082B	Material	:
Written By	:	Due Date	: 4/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>07.04.13</i>		
Comment	: Est Rev: A New issue ecn882 06-11-30 EC est rev B revc dwg 07.01.11 ec est rev C revD dwg 07.03.07 ec		

## Additional Product

*w/o 30020*

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Ship To Delastek

8	D2213	Spacer	Batch: _____
---	-------	--------	--------------

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING  
 Issue P/O: \_\_\_\_\_  
 Description: D31881M BODY  
 Ship: D2213 Spacers  
 Supplier: Delastek  
 Conformity Certificate and Process sheet required  
 Ship 2 Items from Previous steps

3.0	D31881P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 4/12/2007 9:13:41 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 31766B

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*Lu A-De-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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07.04.02

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CHECKED Ce	APPROVED [Signature]	D3188	SHEET 1 OF 11	
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS	
A	03.04.03	NEW ISSUE		
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7		
C	06.12.13	REMOVED D0600-XXX LABELS		
D	07.02.22	UPDATE DIMENSIONS		
E	07.04.02	ADD. HYSOL/FIBER OPTION ON SHEET 11		

**GENERAL NOTES:**

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

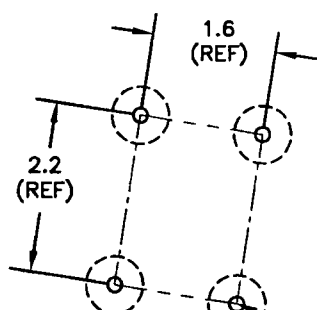
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NO. 31766B

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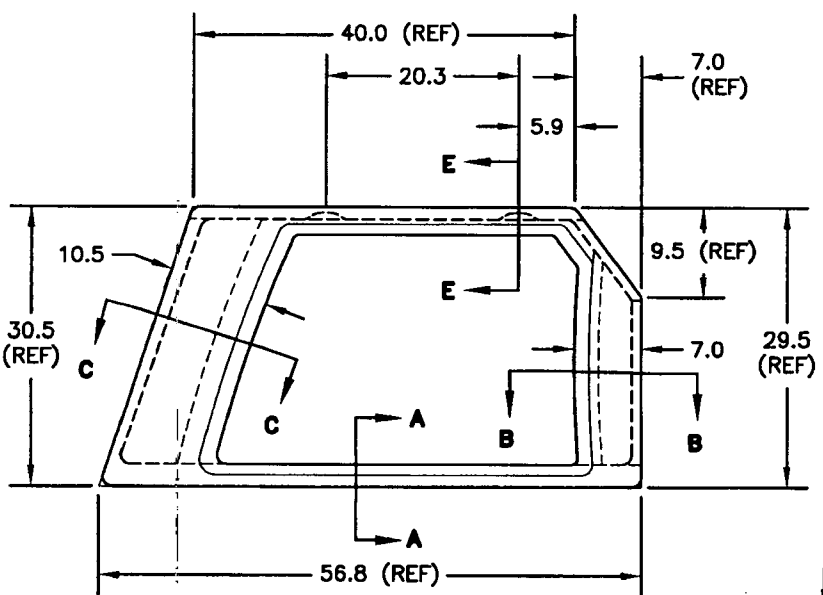
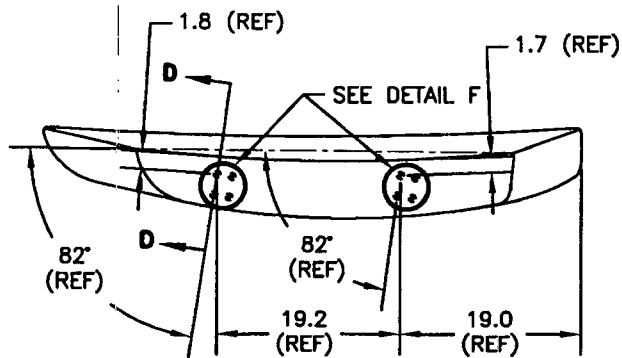
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DATE	07.04.02	TITLE	SPACEPOD BODY	REV. E
				SHEET 2 OF 11
				SCALE NTS

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07-04-01

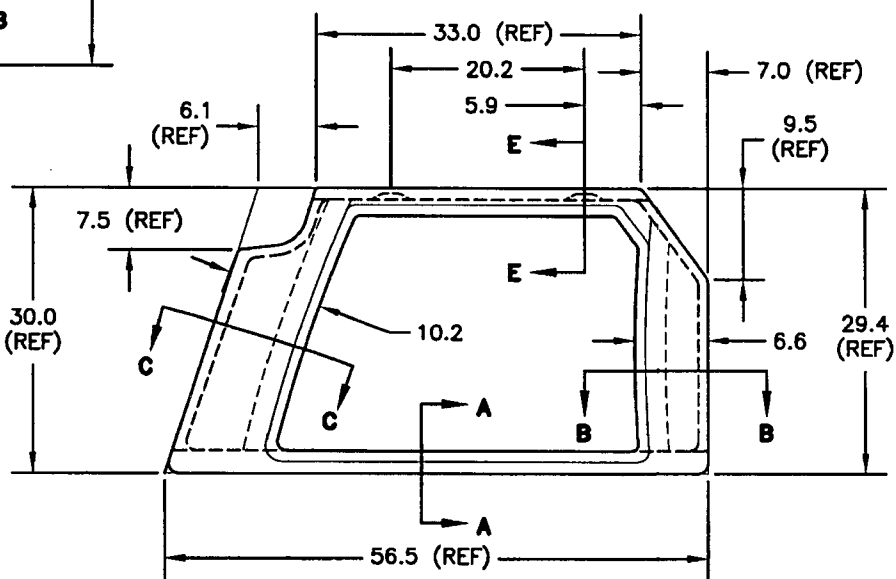
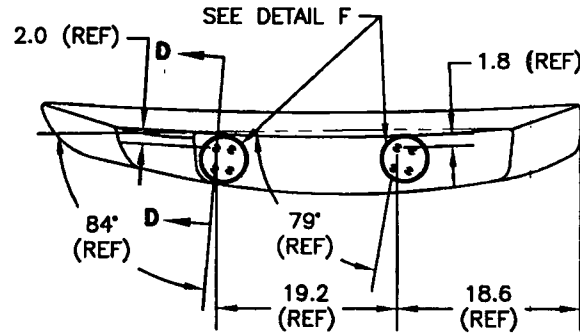


**DETAIL E**

INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**D3188-1M SPACEPOD BODY**



**D3188-3M SPACEPOD BODY**

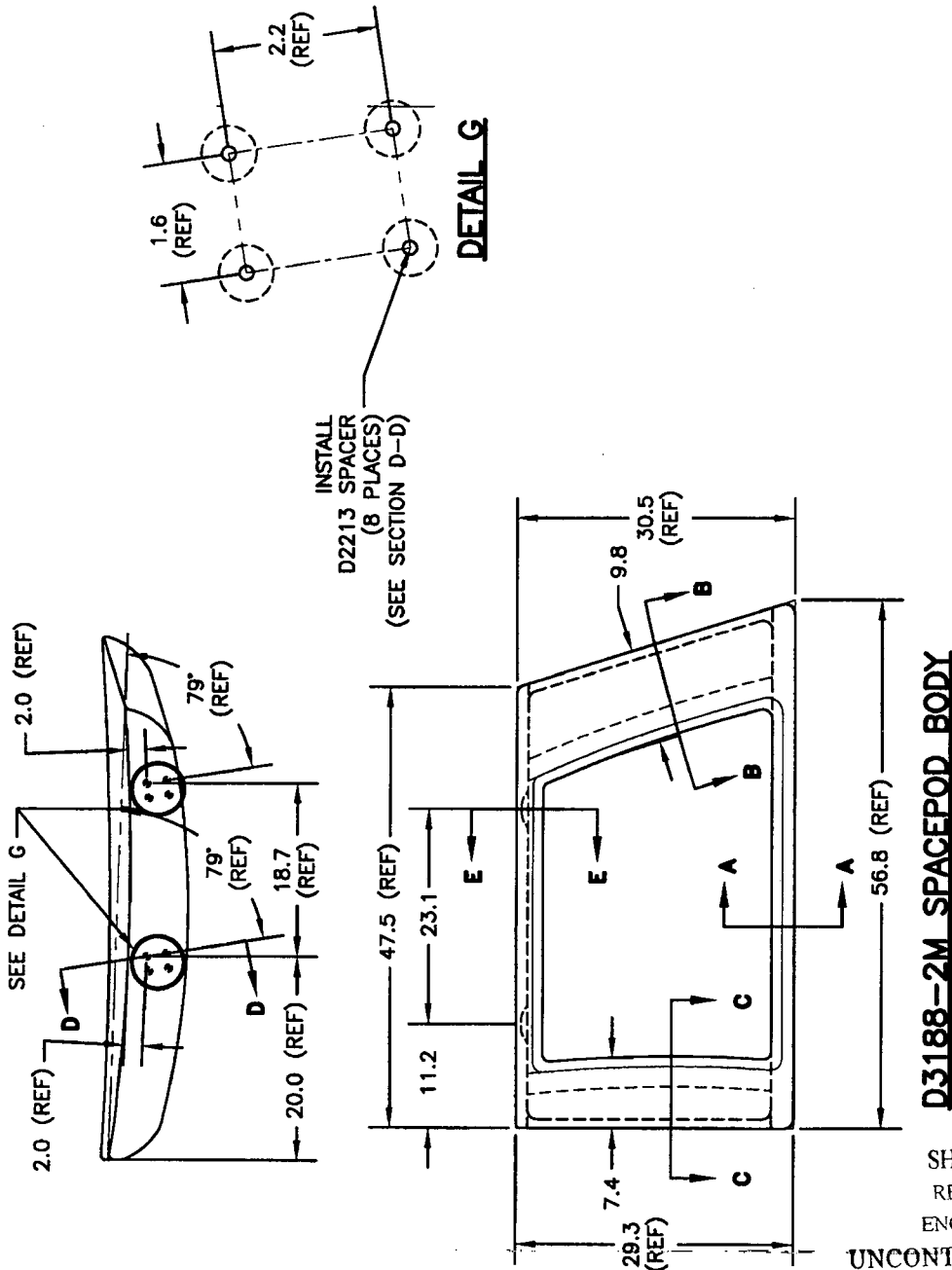
**D3186-1M/-3M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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WORK ORDER  
NO. 31766P

**DART**

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CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3188</b>	REV. E SHEET 3 OF 11
DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS

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**D3186-2M NOTES:**  
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.  
2) SEE SHEET #4 FOR SECTION VIEWS.

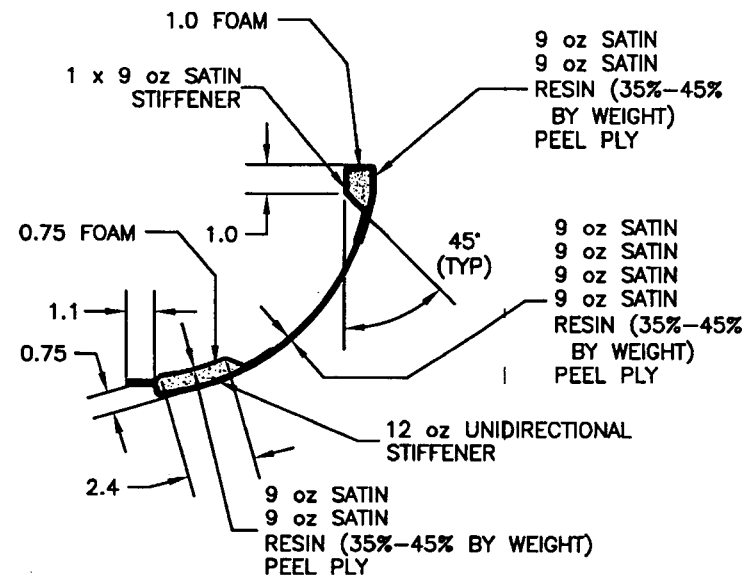
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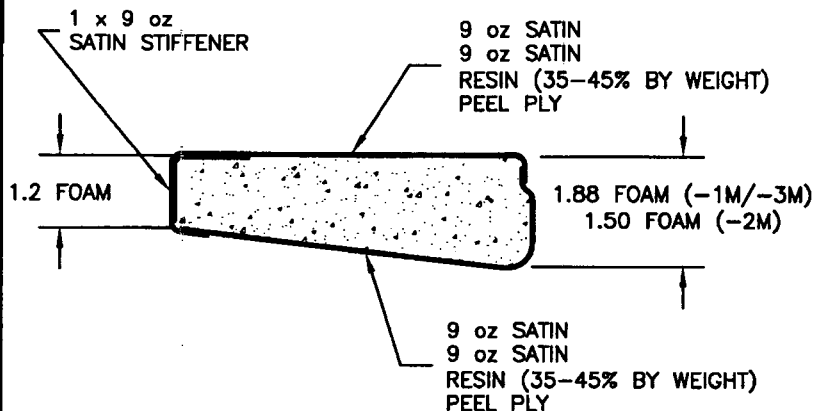
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DATE	07.04.02	DRAWING NO.	D3188	REV. E
		TITLE	SPACEPOD BODY	SHEET 4 OF 11
		SCALE	NTS	

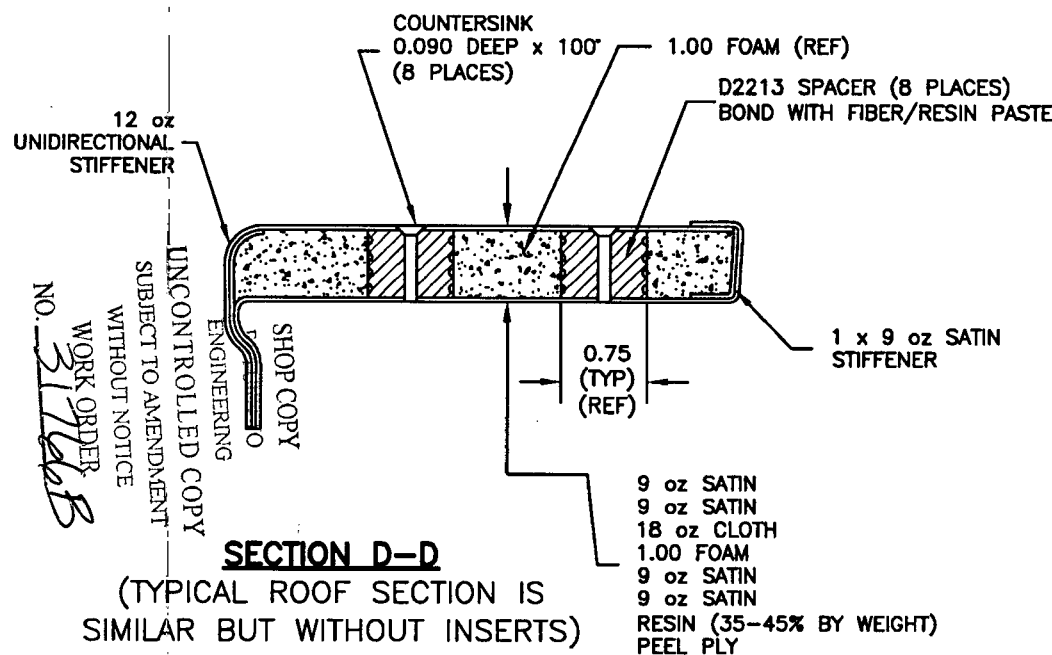
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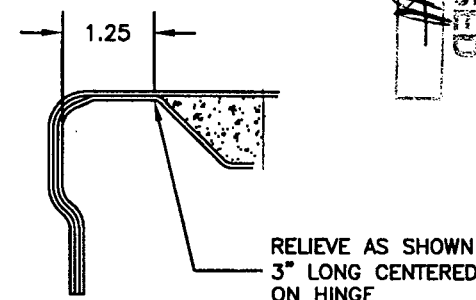
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)



**SECTION E-E**  
(2 PLACES PER POD)

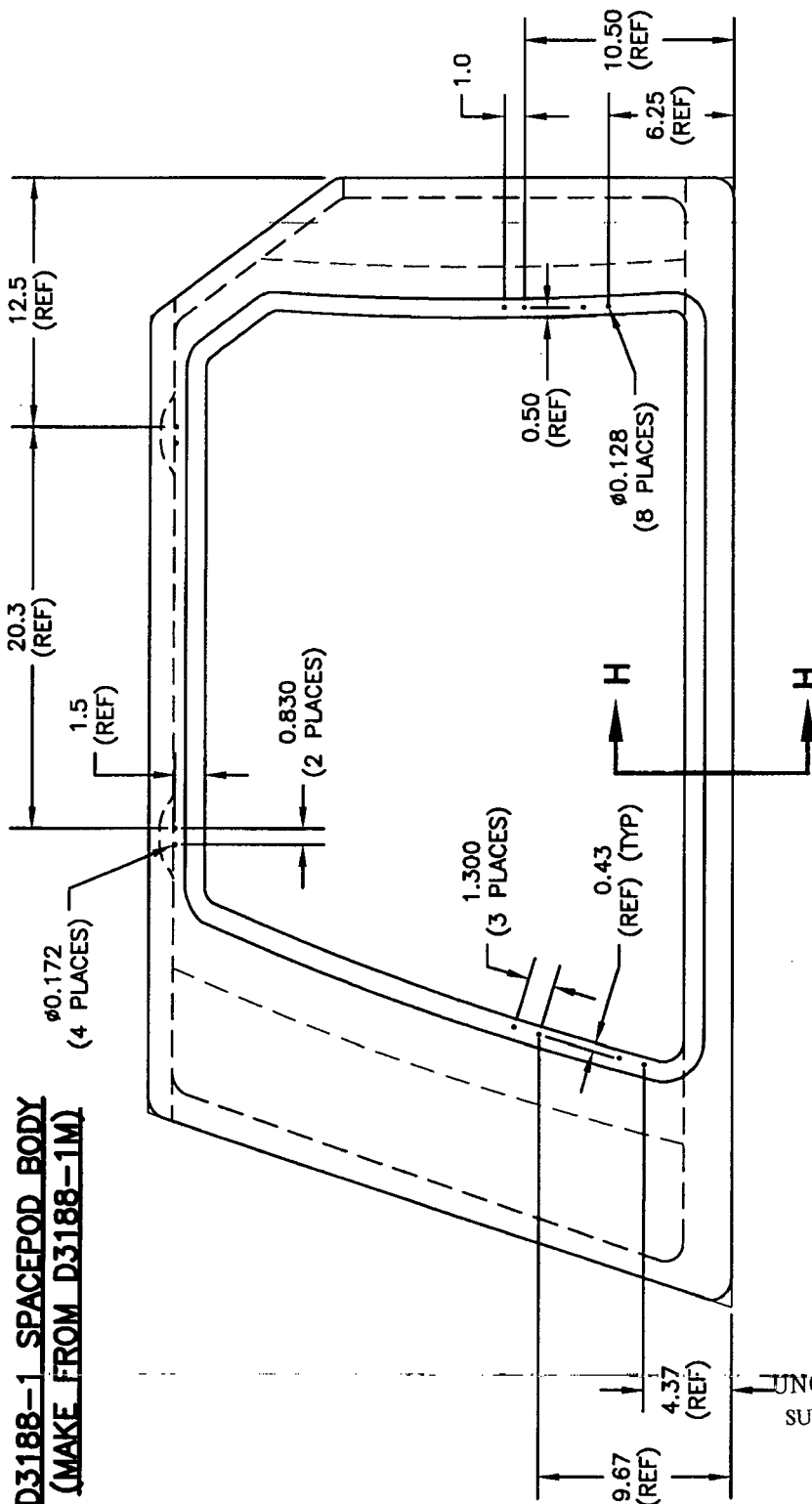
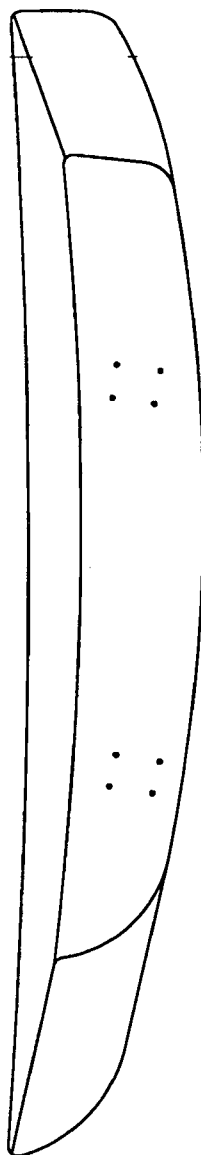


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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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07.04.02



**D3188-1 SPACEPOD BODY  
(MAKE FROM D3188-1M)**

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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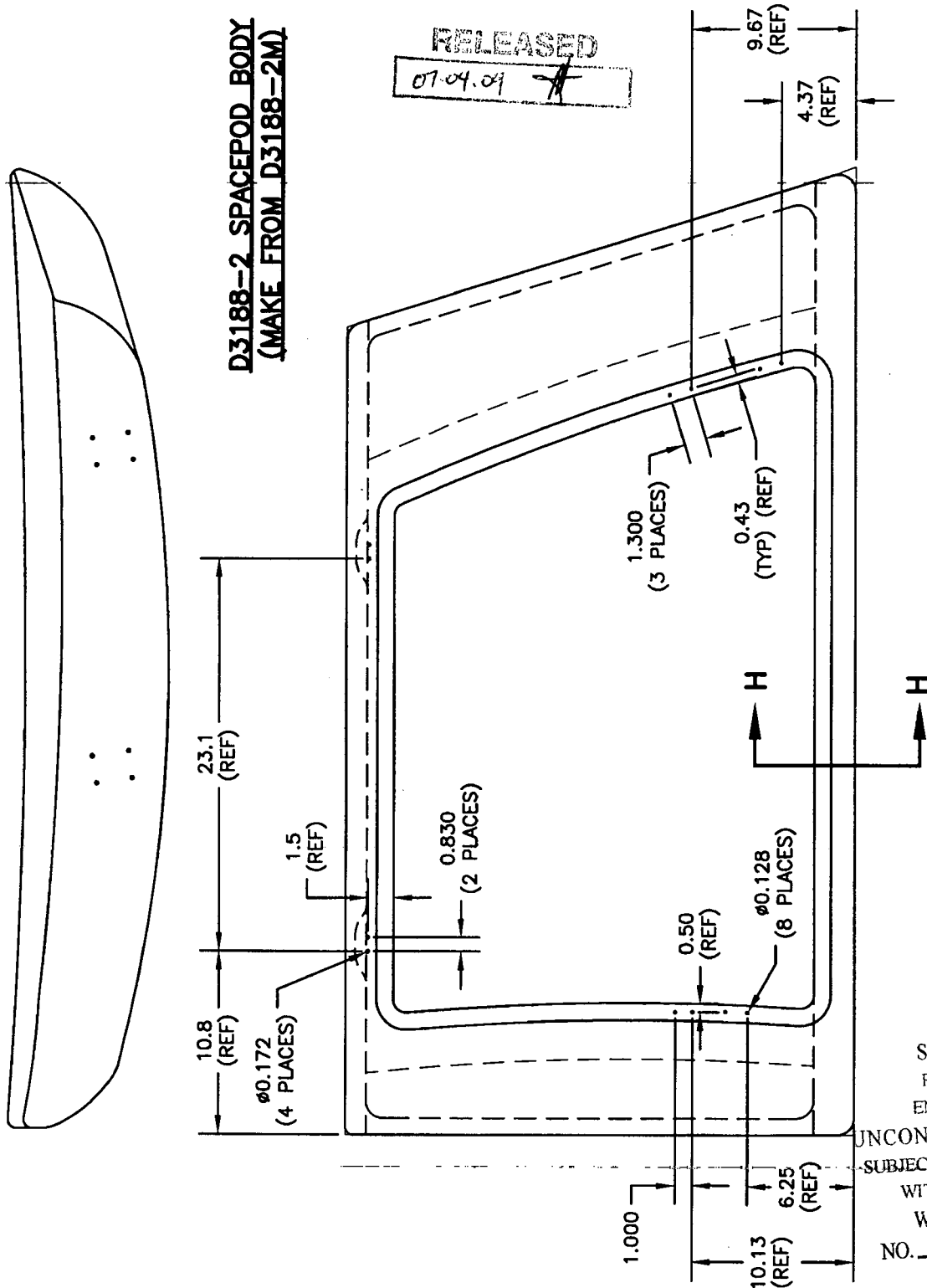
WORK ORDER  
NO. 31766B

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



NOTES:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEW

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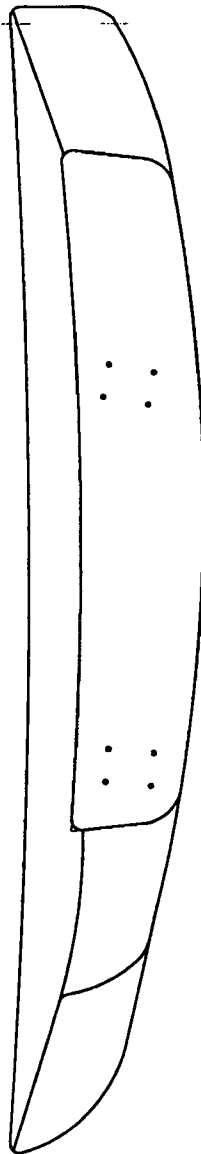
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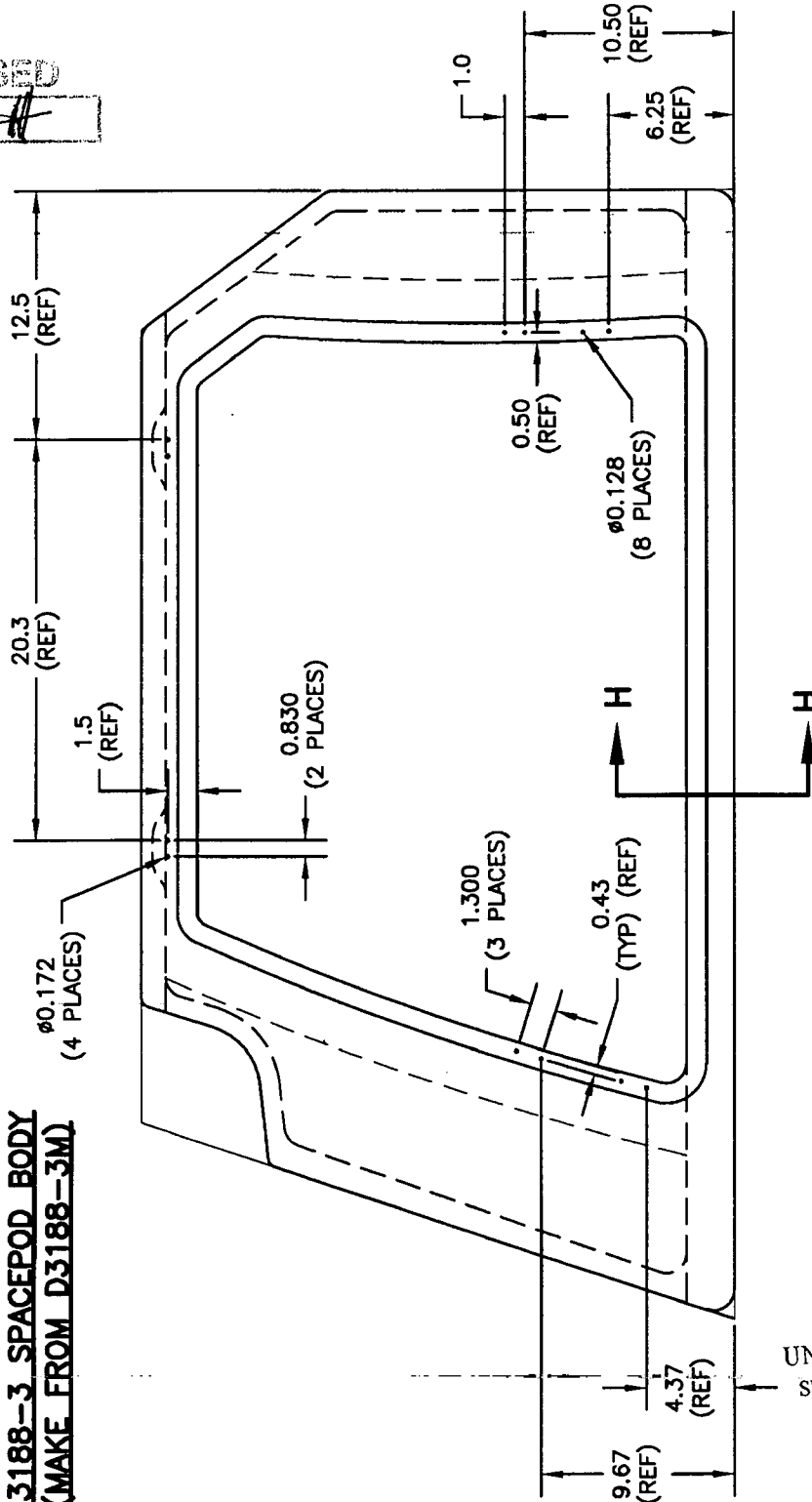
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.09



**D3188-3 SPACEPOD BODY  
(MAKE FROM D3188-3M)**

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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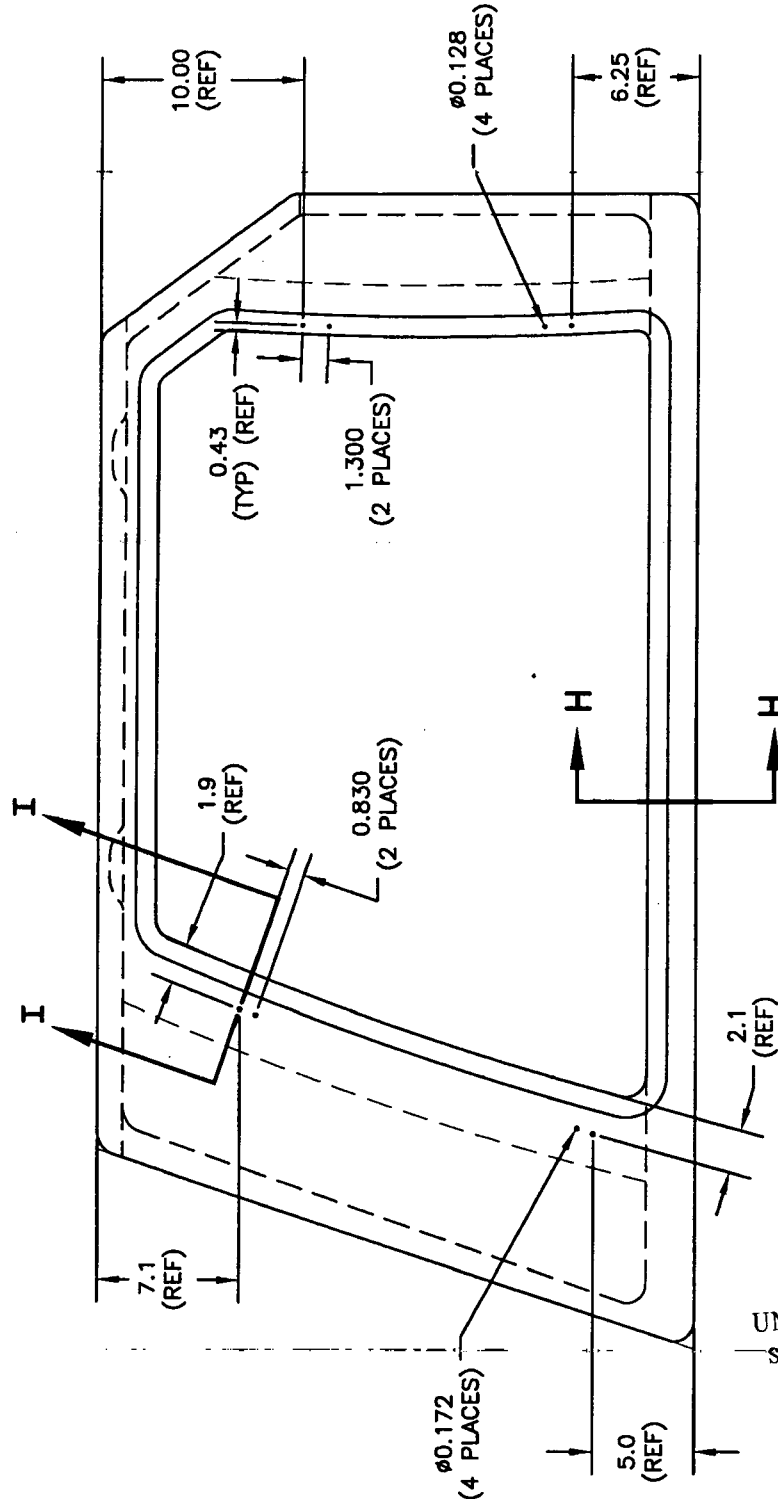
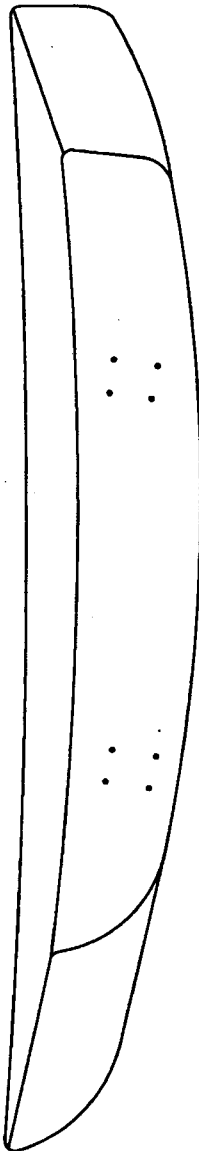
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02 H

**D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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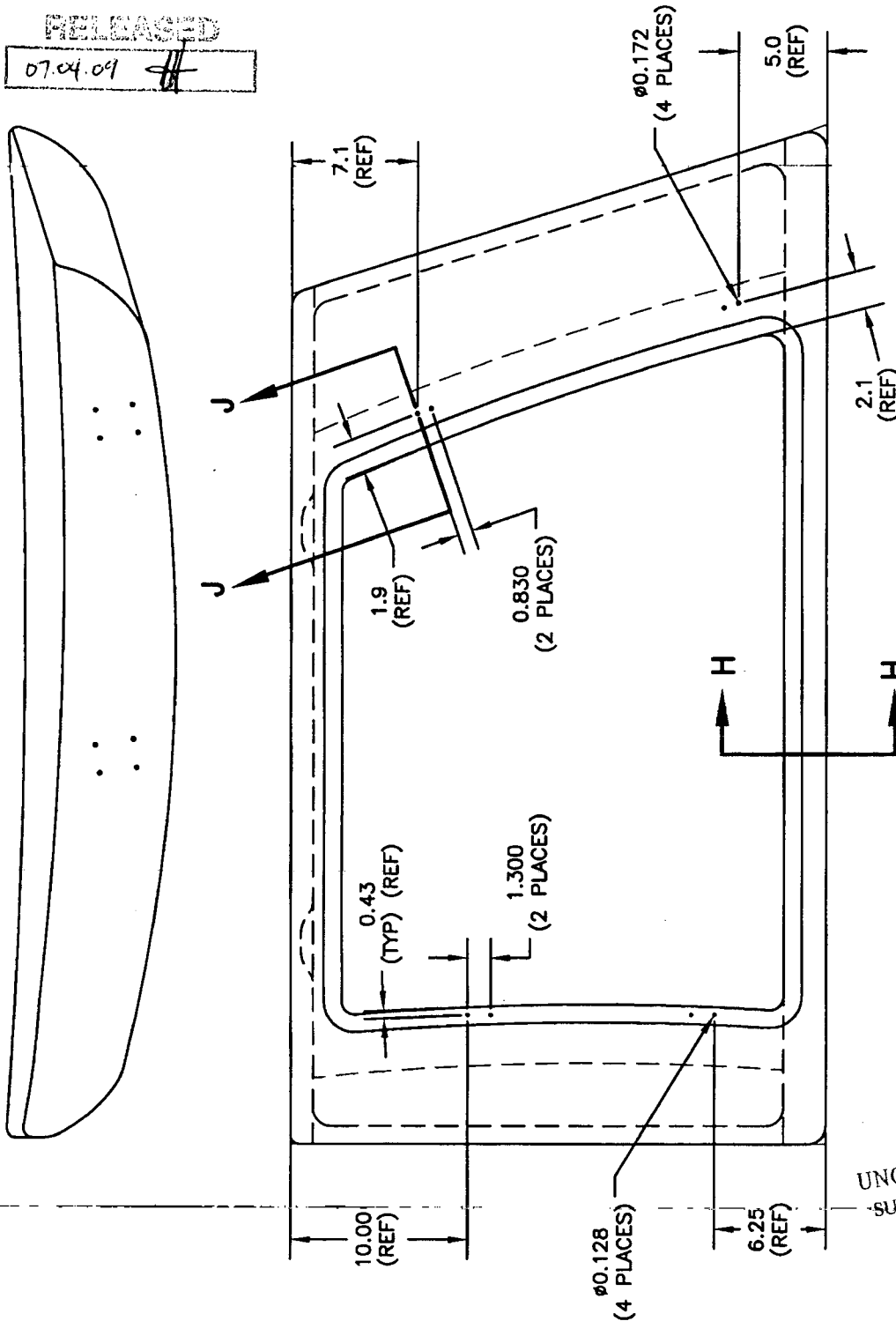
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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE <b>NTS</b>

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**D3188-6 SPACEPOD BODY**  
**(MAKE FROM D3188-2M)**



NOTES:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEWS

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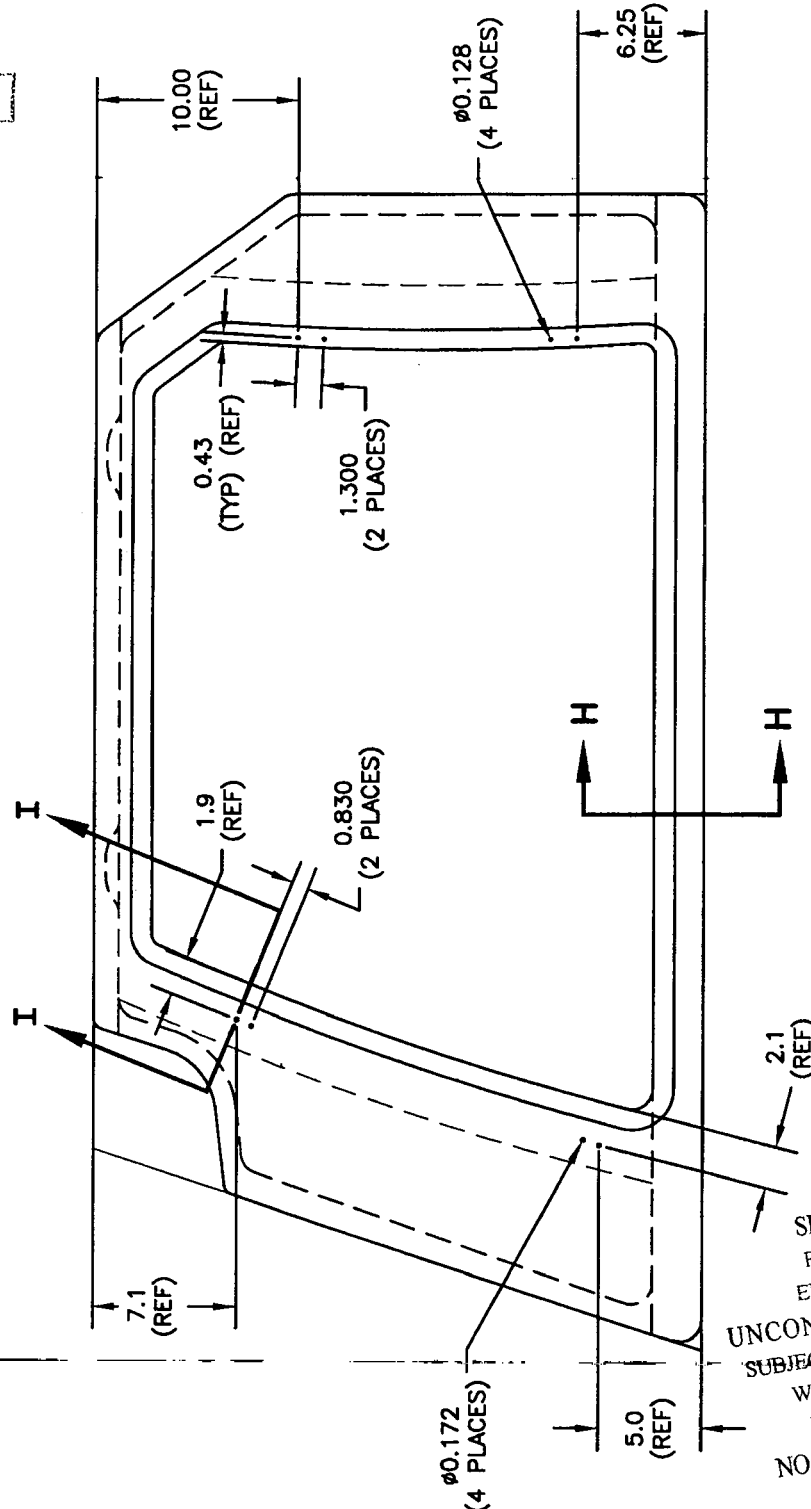
**DART**

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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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07.04.02

**D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



**NOTE:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS

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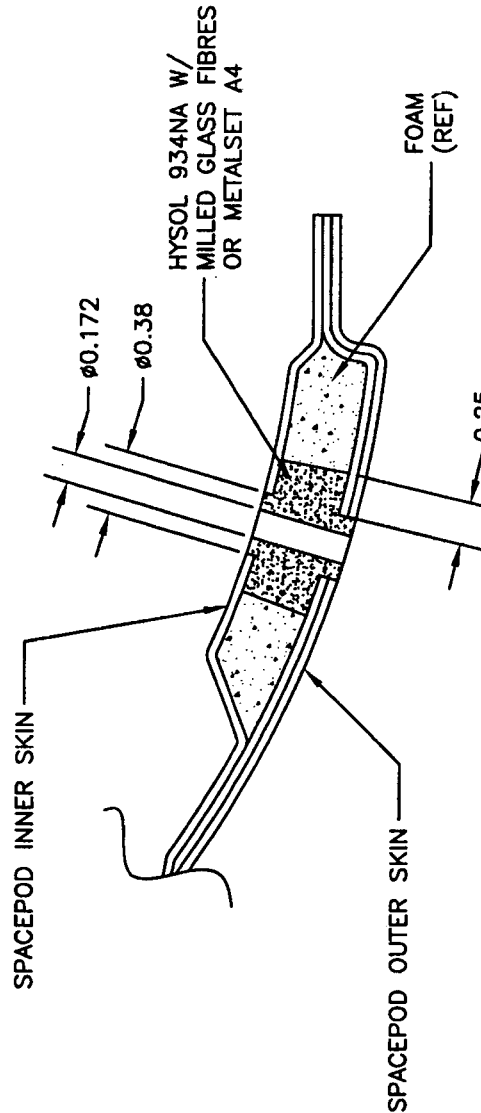
01.04.09 **[Signature]**

INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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Date: Jeudi, 2007-03-29 10:32:35  
 Utilisateur: Marc Dubé

## Feuille de Procédé

<b>Client</b> :	DART Dart Aerospace Ltd.	<b>Nom Dessin</b> :	SPACEPOD BODY
<b>Numéro Job</b> :	41301	<b>Numéro Article</b> :	DKC134-0053
<b>Numéro Soumission</b> :	2585	<b>Numéro Dessin</b> :	D3188
<b>Numéro B.A.</b> :		<b>Projet Numéro</b> :	DKC134
<b>Cette fois</b> :	2007-03-29	<b>Révision dessin</b> :	C
<b>Prsht Rev.</b> :	NC	<b>Matériel</b> :	Fibre 7781 et Résine 411-350
<b>Prem. fois</b> :	--	<b>Date Dûe</b> :	2007-04-05
<b>Job précédente</b> :	41300	<b>Qté:</b>	1 Udm: UNITE

Type : 

Écrit par : \_\_\_\_\_  
 Vérifié & Approuvé par : \_\_\_\_\_  
 Commentaires : N° de pièce Dart Aerospace : D31881M

Process Sheet Rev.: 01 Modification générale selon informations de l'ingénierie.

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)  
 Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
 PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8003 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

MAY 02 2007

 Date: \_\_\_\_\_ Heure Début: 8:00 Heure Fin: 11:00 Sceau: 

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)  
 Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)  
 Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)  
 Feutre de drainage N° Airweave N 10

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)  
 Stretchlon 200 poche à vide Vert



## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41301

Numéro Article: DKC134-0053

Numéro Job:



# Séq.: Machine ou Opération: Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 11.400 VERGE(s)/Unit Total: 11.400 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

#LOT 1-6083-1

8.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 RL(s)/Unit Total: 4.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

9.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total: 0.80 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-5964-1

10.0 AAC0633 WR1850 ROVING 18 OZ x 50"

Commentair Qty.: 0.35 VERGE(s)/Unit Total: 0.35 VERGE(s)

WR1850 ROVING 18 OZ x 50"

N° de Lot: 1-5873-1

11.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 3/05/07 Heure Début: 8:00 Heure Fin: 12:00 Sceau:



12.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total: 0.0640 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

13.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 KILOGRAMME(s)/Unit Total: 2.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6133-1

14.0 AAC0673 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0039 GALLON(s)/Unit Total: 0.0039 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41301Nom Dessin: SPACEPOD BODY  
Numéro Article: DKC134-0053

Numéro Job:



# Séq.: Machine ou Opération: Description :

Préparer une seringue rempli de 30 ml de résine chargé de fibre dde verre Mia Poxxy 66.

MAY 08 2007

Date: \_\_\_\_\_ Heure Début: 10:15 Heure Fin: 10:25 Sceau: \_\_\_\_\_



16.0

LAMINAGE.

LAMINAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue. Faire un joint tout autour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8003 et ensuite imbiber un pli de tissu 9.7oz. et un 18 oz. sur la section supérieur de la pièces.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

MAY 08 2007

Date: \_\_\_\_\_ Heure Début: 10:25 Heure Fin: 11:25 Sceau: \_\_\_\_\_



17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Film Perforé P-3
- 3- Feutre de drainage.
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures Minimum.

MAY 08 2007

Date: \_\_\_\_\_ Heure Début: 11:05 Heure fin: 11:25 Sceau: \_\_\_\_\_



Curing Début: 10:25 Curing Fin: 4:00

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit Total: 0.75 FEUILLE(s)  
ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot:

3-5915-2

Date: Jeudi, 2007-03-29 10:32:35

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41301

Numéro Article: DKC134-0053

Numéro Job:




# Séq.: Machine ou Opération: Description :

19.0 FAB GÉNÉRALE 3 FABRICATION GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs  
TAILLAGE DU MATÉRIEL

Tailler et le Foam Core 1" selon plan de découpe et gabarits

Date: 4/05/07 Heure Début: 8:00 Heure Fin: 10:00 Sceau: 

20.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6133-1

21.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-5921-3

22.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

MAY 09 2007



M.A.

Prendre les deux pièces de 11" x 57" et sceller 1 grande surface sur chacune d'elle selon I.G. # Sceller le  
Foam Core.

23.0 AAC0452 Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)  
Polybond B46F

N° de Lot: 1-6066-1

24.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

À l'aide de polybond, coller ensemble les deux surfaces scellées

Disposer des poids sur les pièces pour conserver une pression de collage.

Laisser sécher 2 heures minimum.

Quantité: 1

Date: MAY 09 2007

Sceau:



M.A.

Date: Jeudi, 2007-03-29 10:32:35

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41301

Numéro Article: DKC134-0053

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
TRIMAGE COMPOSITES DART

Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam core dans le moule selon le dessin.

Quantité: 1 Date: MAY 09 2007 Sceau: M.A.

Quantité: \_\_\_\_\_ Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6133-1

27.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-5921-3

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
PRÉPARATION DU MATÉRIEL DART

MAY 10 2007



Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par  
quantité de résine N° 411-350 promu 75 minutes..

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
FABRICATION GÉNÉRALE DART

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G. # Sceller le Foam Core

Laisser sécher pendant 2 heures minimum.

Date: MAY 10 2007 Sceau: 32 Initiales: M.G.

Date: Jeudi, 2007-03-29 10:32:35

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41301

Numéro Article: DKC134-0053

Numéro Job:



# Séq.: Machine ou Opération: Description :

30.0 AAC0452 Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)

Polybond B46F N° de Lot: 1-6066-1

31.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation du Polybond.

Date: MAY 11 2007 Heure Début: 10:15 Heure Fin: 10:25 Sceau:



32.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: MAY 11 2007 Heure Début: 10:25 Heure Fin: 16:50 Sceau:



33.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE

Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé

Date: MAY 11 2007 Heure Début: 10:50 Heure Fin: 11:10 Sceau:



Curing Début: 10:25 Curing Fin: 11:30

34.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.100 UNITE(s)/Unit Total: 0.100 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6079-1

Date: Jeudi, 2007-03-29 10:32:35

Utilisateur: Marc Dubé

## Feuille de Procédé

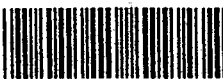
Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41301

Numéro Article: DKC134-0053

Numéro Job:



# Séq.: Machine ou Opération: Description:

35.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total: 0.078 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

36.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs  
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plos gros défauts, utiliser du polybond.

Date: 16/05/07 Heure Début: 12:30 Heure Fin: 4:00 Sceau:  

37.0 TRIMAGE 3 TRIMAGE COMPOSITES DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
TRIMAGE COMPOSITES DART

Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.

16/05/07



38.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.100 KILOGRAMME(s)/Unit Total: 0.100 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6133-1

39.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0032 PINTE(s)/Unit Total: 0.0032 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-5921-3

40.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
FINITION PIÈCE DART

Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le fom Core

Laisser sécher pendant 2 heures minimum.

Quantité: 1 Date: 17/05/07 Sceau: 

Quantité: Date: Sceau:

Date: Jeudi, 2007-03-29 10:32:35

Utilisateur: Marc Dubé

## Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41301

Numéro Article: DKC134-0053

Numéro Job:



# Séq.: Machine ou Opération: Description :

41.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-5921-3

42.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6133-1

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 8/05/07 Heure Début: 8:10 Heure Fin: 8:15 Sceau:

44.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: 8/05/07 Heure Début: 8:15 Heure Fin: 9:00 Sceau:

45.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: Jeudi, 2007-03-29 10:32:36

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41301

Numéro Article: DKC134-0053

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Date: 18/05/07 Heure Début: 9:00 Heure Fin: 9:20 Sceau:



Curing Début: 8:15 Curing Fin: 1:30

46.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

DÉMOULAGE DES PIECES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: 18/05/07 Heure Début: 1:30 Heure Fin: 2:00 Sceau:



47.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

TRIMAGE DE FINITION

Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit de N° DT5801.

Par l'intérieur, percer les 8 dégagement de ø .745" pour les spacers. ( Ne pas percer la peau extérieur de la pièce )

Date: 18/05/07 Heure Début: 2:00 Heure Fin: 2:45 Sceau:



48.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

49.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6148-1

50.0

AAC0673

Fibre de verre Miapoxy 66

Commentaire Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1



Date: Jeudi, 2007-03-29 10:32:36

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41301

Numéro Article: DKC134-0053

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

51.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

MAY 22 2007

Date: 12:30 Heure Début: 12:35 Heure Fin: 1:05 Sceau:

52.0

AAC0448

Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s)

Spacer N° D2213

N° de Lot: 1-5949-1

53.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

ASSEMBLAGE GÉNÉRALE DES PIÉCES

Faire l'assemblage des inserts ( Spacer ) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre Miapoxy 66

Laminer une pièce de 9 oz. sur chacune des 2 zones de 4 spacers.pour reboucher les trous.

Appliquer un pression sur les pièces de 9 oz. à l'aide d'un bloc de bois et de pinces autobloquantes.

Laisser sécher pendant 4 heures minimum.

MAY 22 2007

Date: 12:35 Heure Début: 1:05 Heure Fin: Sceau:

Curing Début: 12:35 Curing Fin: 8:00

54.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

55.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6148-1

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41301

Numéro Article: DKC134-0053

Numéro Job:



# Séq.: Machine ou Opération: Description :

56.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: MAY 22 2007

Heure Début: 8:00

Heure Fin: 8:05

Sceau:



57.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs  
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et les blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièce selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date: MAY 22 2007

Heure Début: 8:05

Heure Fin: 8:35

Sceau:



Curing Début: 8:05

Curing Fin: 12:35

58.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
FINITION PIÈCE DART

Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections.

Percer les 8 trous des spacers afin de les déboucher.

Quantité: 1

Date: MAY 23 2007

Sceau:



Quantité: 1

Date: 25-5-07

Sceau:



59.0

AAC0671

Dupont Primer N° 1104S

Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)  
Dupont Primer N° 1104S

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41301

Numéro Article: DKC134-0053

Numéro Job:



# Séq.: Machine ou Opération: Description :

60.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)  
Dupont Activator N° 7975S

61.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)  
Dupont Reducer N° 12375S

62.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

MAY 25 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

63.0 PEINT/PRIMER2 PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
PEINTURE / PRIMER DART

Appliquer le primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G. Application de primer.

Laisser sécher 3 heures minimum.

Date: MAY 25 2007

Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau: \_\_\_\_\_



64.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6079-1

65.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

66.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide de Sikkens

Faire un léger sablage ( grit 220 ) de toutes les surfaces.

Date: 28-07-07 Heure Début: 11:00 Heure Fin: 1:00

Sceau: \_\_\_\_\_



## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41301

Numéro Article: DKC134-0053

Numéro Job:



# Séq.: Machine ou Opération: Description :

67.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.2500 GALLON(s)/Unit Total : 0.2500 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-6065-2

68.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.5000 PINTE(s)/Unit Total : 0.5000 PINTE(s)  
Dupont Activator N° 7975S N° de Lot: 1-6065-1

69.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0625 GALLON(s)/Unit Total : 0.0625 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: 1-5091-2

70.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

Nettoyages Qty 1 29-05-07

MAY 29 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

71.0 PEINT/PRIMER2 PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  
APPLICATION DE PRIMER

Appliquer deux couches de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les deux couches.

Laisser sécher pendant un minimum de 3 heures.

MAY 29 2007

Date: Heure Début: Heure Fin: Sceau:



72.0 INSPECTION 3 INSPECTION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 31-5-07

Sceau:



Initiales:

31 mai 07



Emballage QT 1



DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLI CERTIFICATE OF COMPLIANCE

Invoice #	11979
Customer #	DART

Telephone: (819) 533-5788  
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
04/06/2007	21/12/2006	5092	C. Lavoie	PO00002767			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30010 Dwg. Rév.: D Job: 41319 U de M : Ea			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30020 Dwg. Rév.: D Job: 41301 U de M : Ea			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30030 Dwg. Rév.: D Job: 41329 U de M : Ea			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30040 Dwg. Rév.: D Job: 41310 U de M : Ea			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357

Date: Wednesday, 12/20/2006 1:44:21 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 30010		
Estimate Number	: 12598		
P.O. Number	: <u>N/A</u>	Part Number	: D31861M
This Issue	: 12/20/2006 S.O. No. : <u>N/A</u>	Drawing Number	: D3186 REV <u>BC</u> <u>LE</u> 07.01.18
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : PURCHASED PARTS	Drawing Revision	: <u>BC</u> <u>LE</u> 07.01.18
Previous Run	: 30009	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 1/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>[Signature] 06/12/20</u>		
Comment	: Est Rev: A New Issue 06-12-04 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 2767

Description: D3186-1M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

C206/12/21 D

2.0	D31861P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from  
 Delastek is attached.

7/6/6 88 [Signature]

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 . Visual inspection. Check for void spot and pins.

m/07/06/07

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GAm/07/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 20/01/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/20/2006 1:44:21 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 30010

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*209104/21*

Job Completion



*U 57.06.21*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

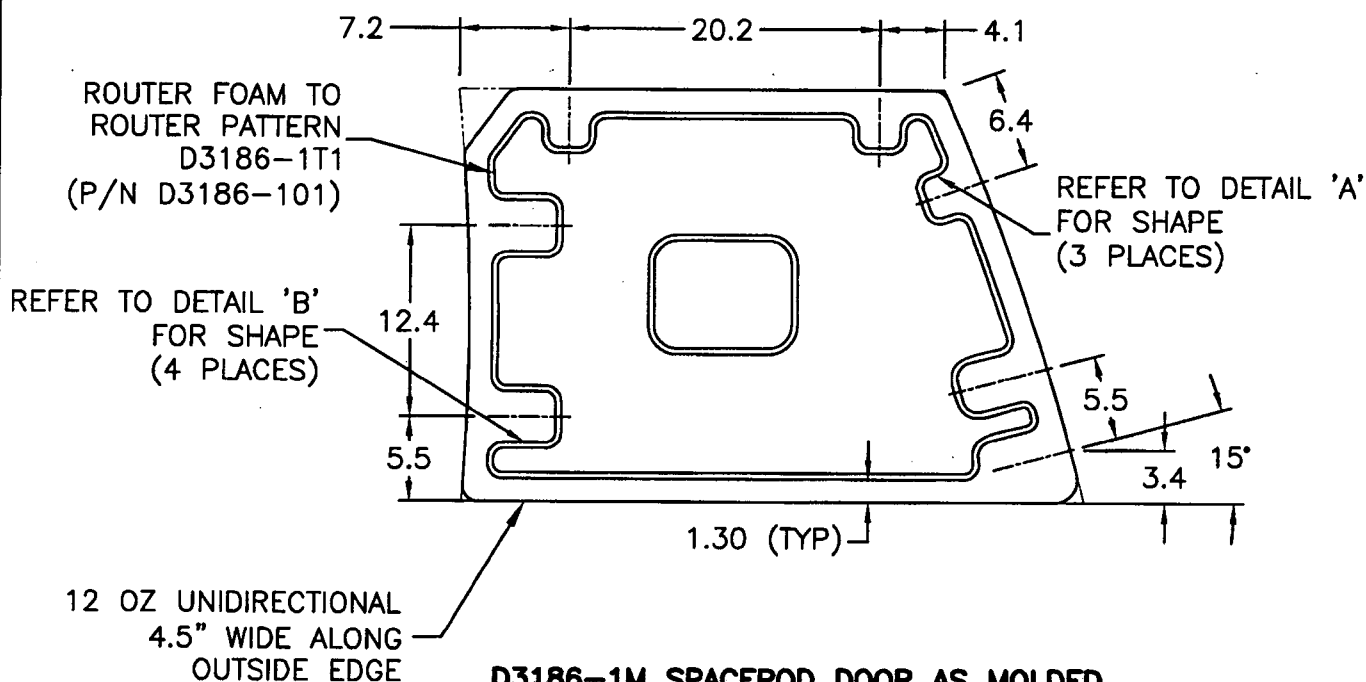
**NOTE:** Date & initial all entries

**DART**

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**D3186-1M SPACEPOD DOOR AS MOLDED****RELEASED**  
06.12.22**NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30010

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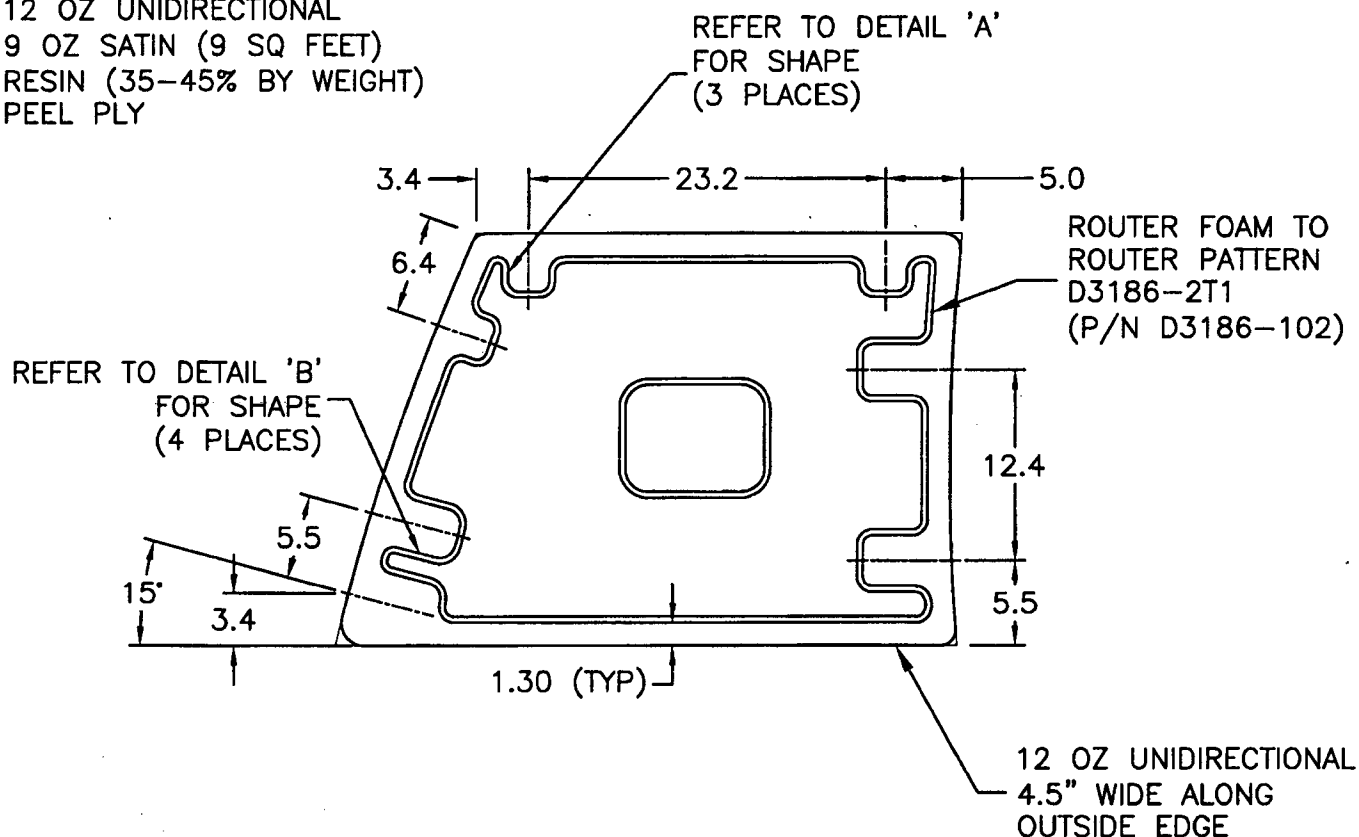


DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 2 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

#### MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

RELEASED  
06.12.13



**D3186-2M SPACEPOD DOOR AS MOLDED**

#### NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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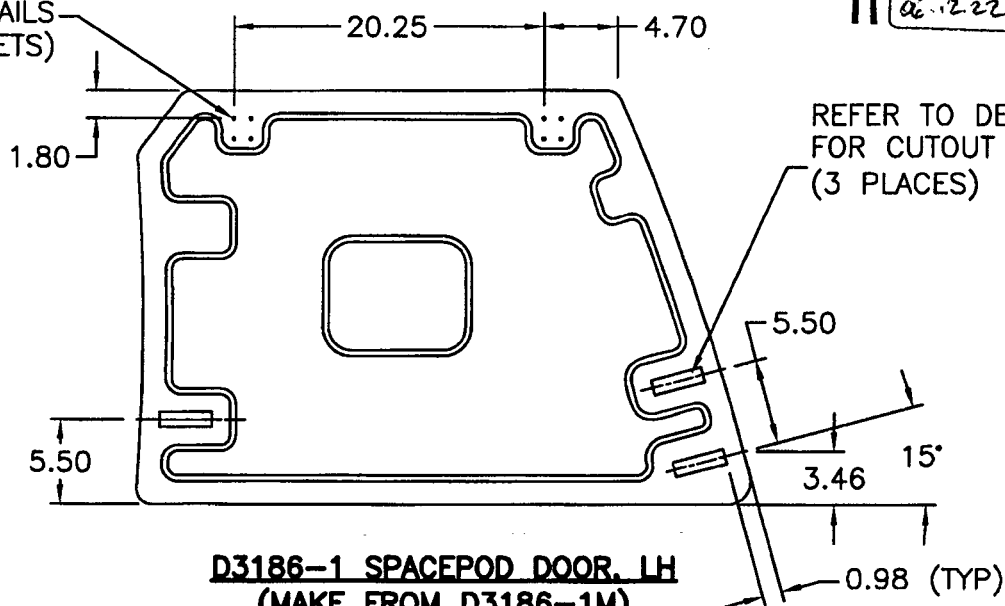
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DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

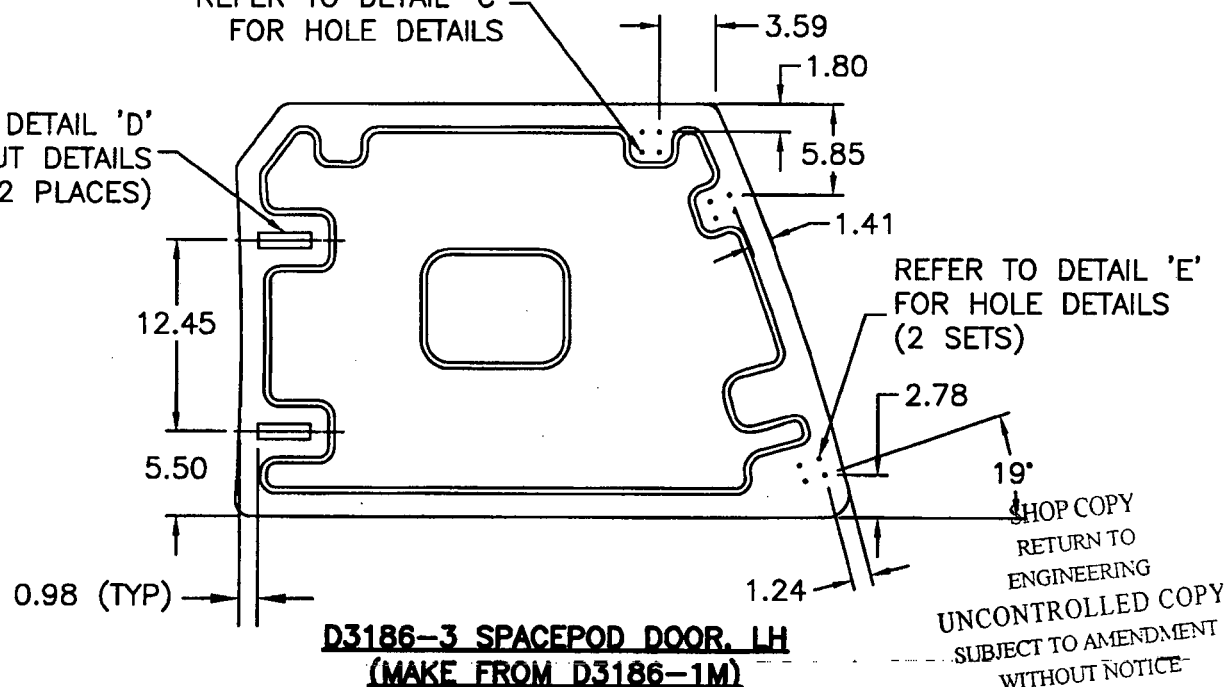
RELEASED  
06.12.22 [Signature]

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)



REFER TO DETAIL 'C'  
FOR HOLE DETAILS

REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(2 PLACES)



**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
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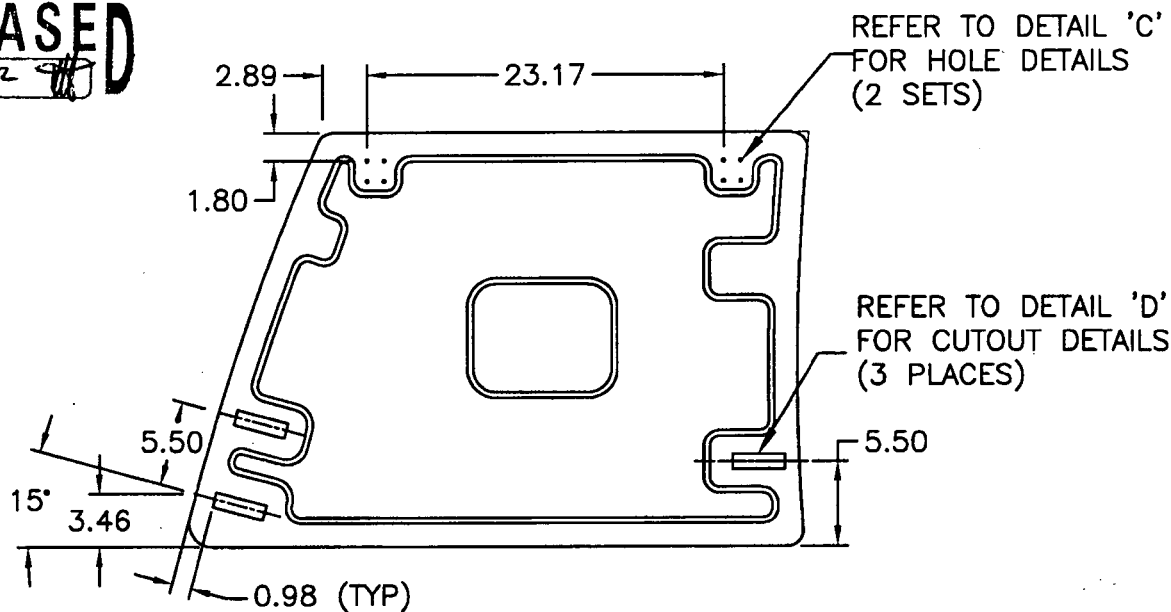
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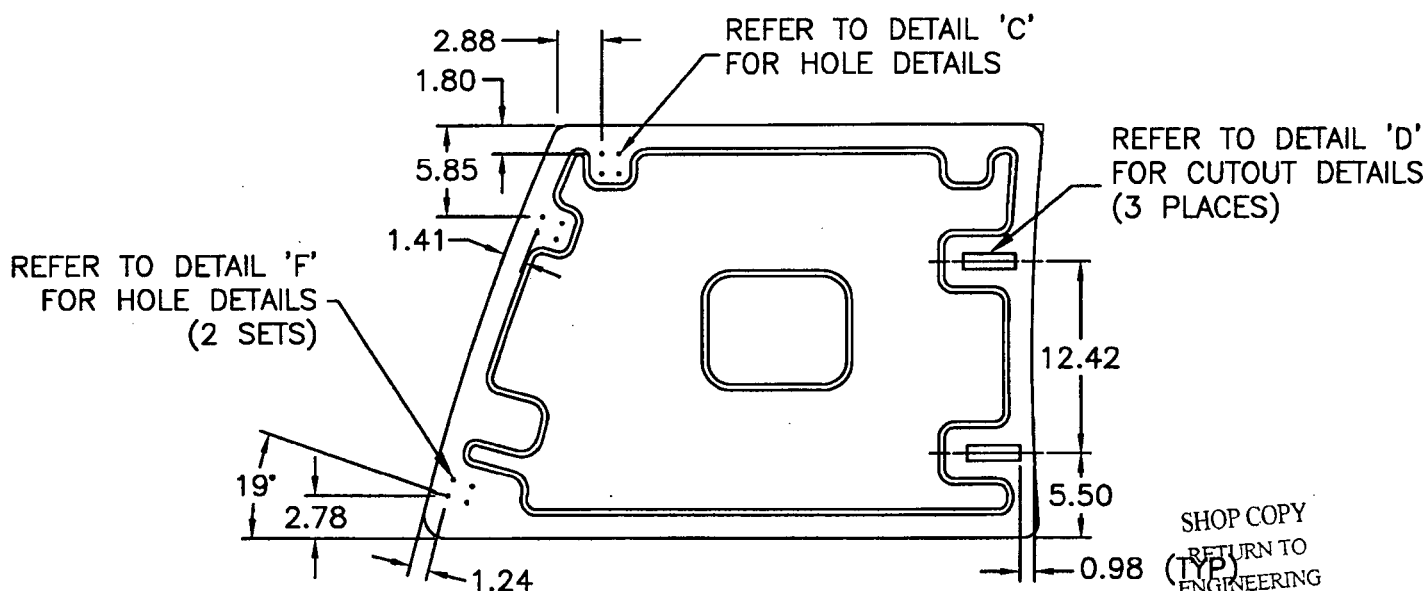


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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 4 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED  
06.12.22



**D3186-2 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

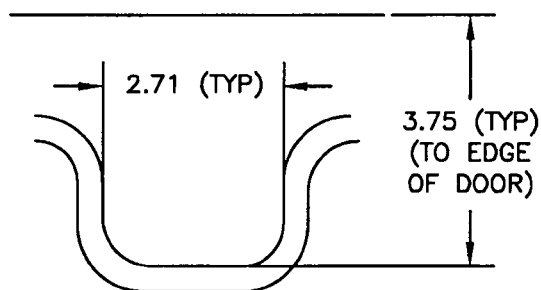
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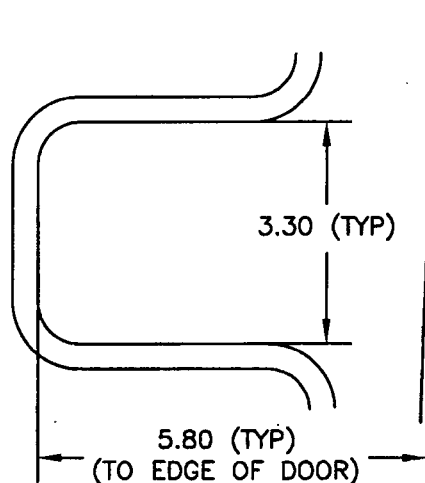
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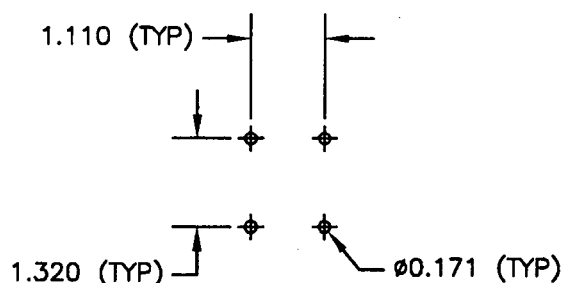
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 5 OF 5
DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



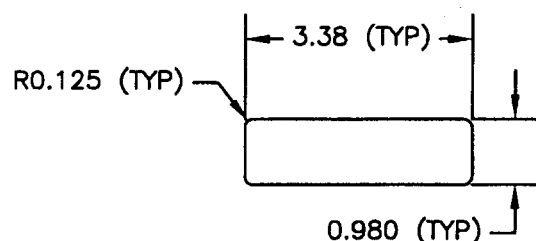
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**DETAIL B**

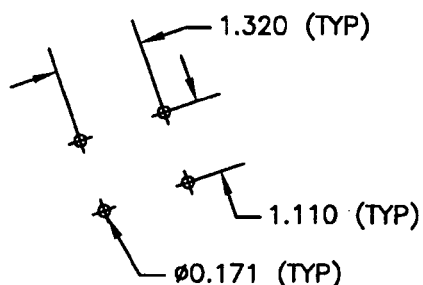


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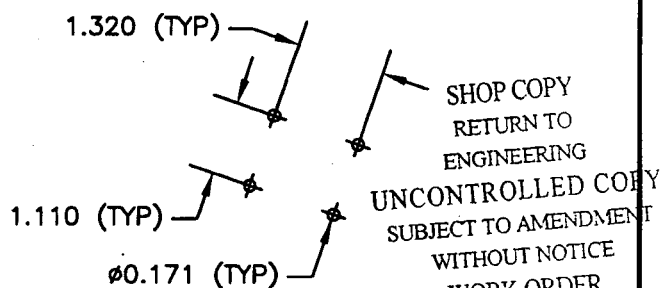


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



**DETAIL F**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
06.12.22

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Date: Thursday, 4/12/2007 9:13:41 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 31766C		
Estimate Number	: 11095		
P.O. Number	: N/A	Part Number	: D31861
This Issue	: 4/12/2007 S.O. No. : N/A	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: D
Previous Run	: 31047C	Material	: N/A
		Due Date	: 4/30/2007
Written By	:	Qty:	1 Um: Each
Checked & Approved By	: <u>4/07/04.13</u>		
Comment	: Est Rev. New Issue 05-11-29 JLM		

## Additional Product

Job Number:



Seq. #.	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	31766C01	SPACEPOD DOOR LH
-----	----------	------------------



30010



Comment: Sub-Component SPACEPOD DOOR LH

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Drill holes and cut out latch slots per dwg D3186 (D3186-1 detail)

ml 07/06/11

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/11 (1)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: GA

ml 07/06/11

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

10/06/21 (1)

Job Completion



U 07-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   A   Date: 07/04/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

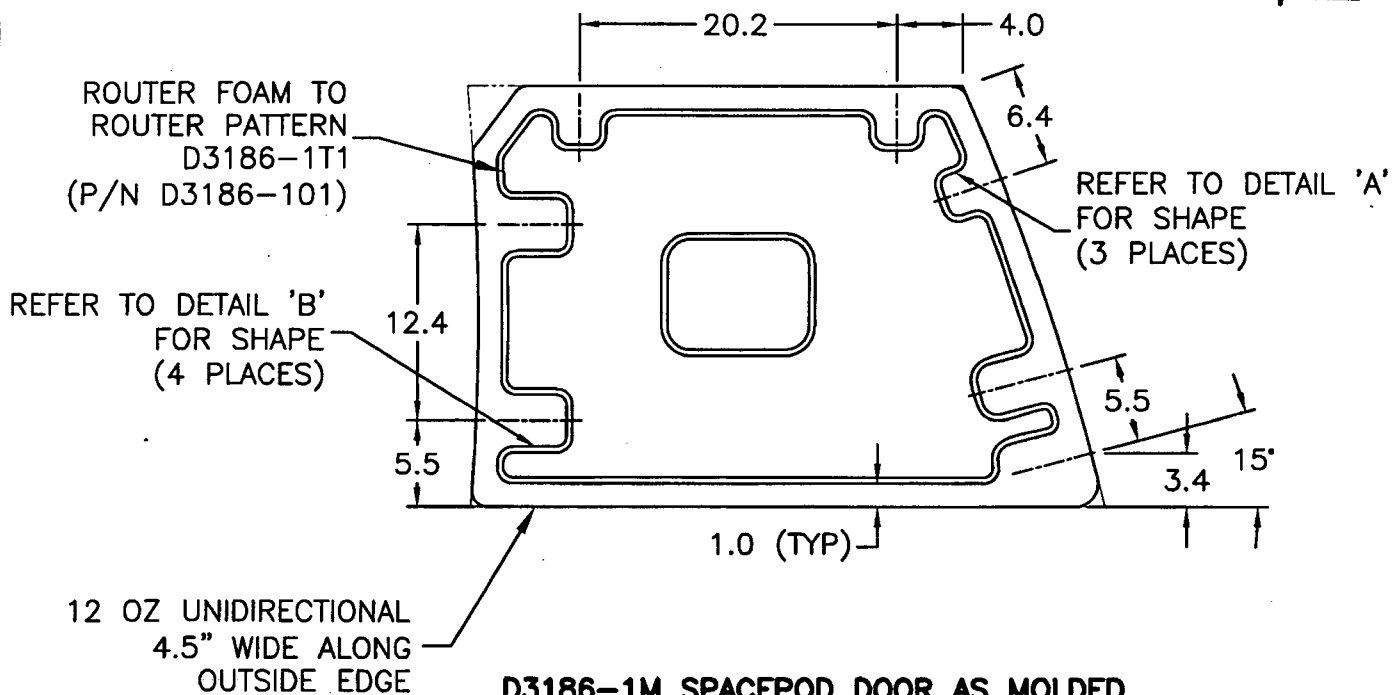
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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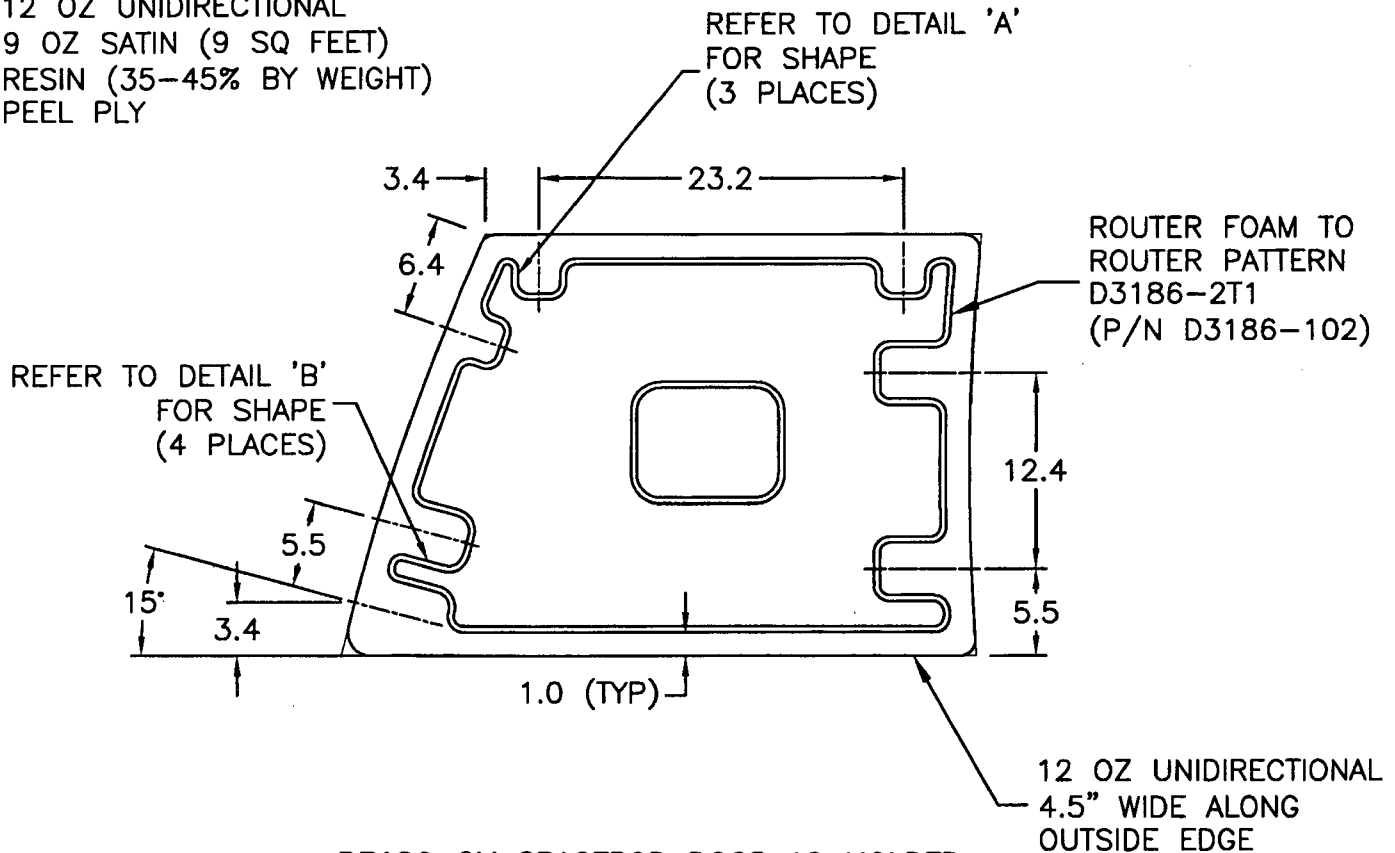
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
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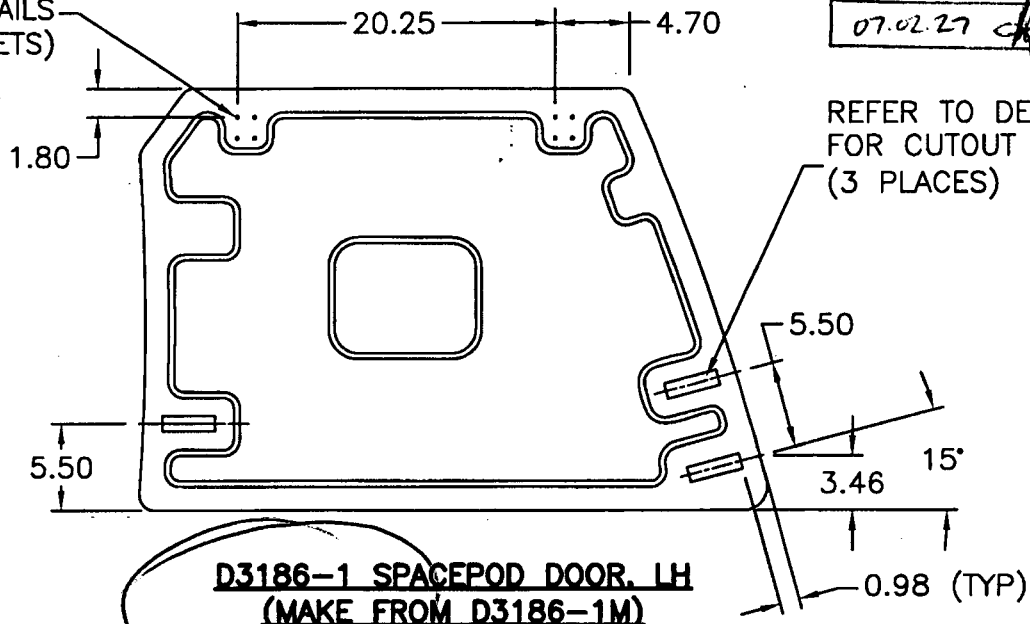
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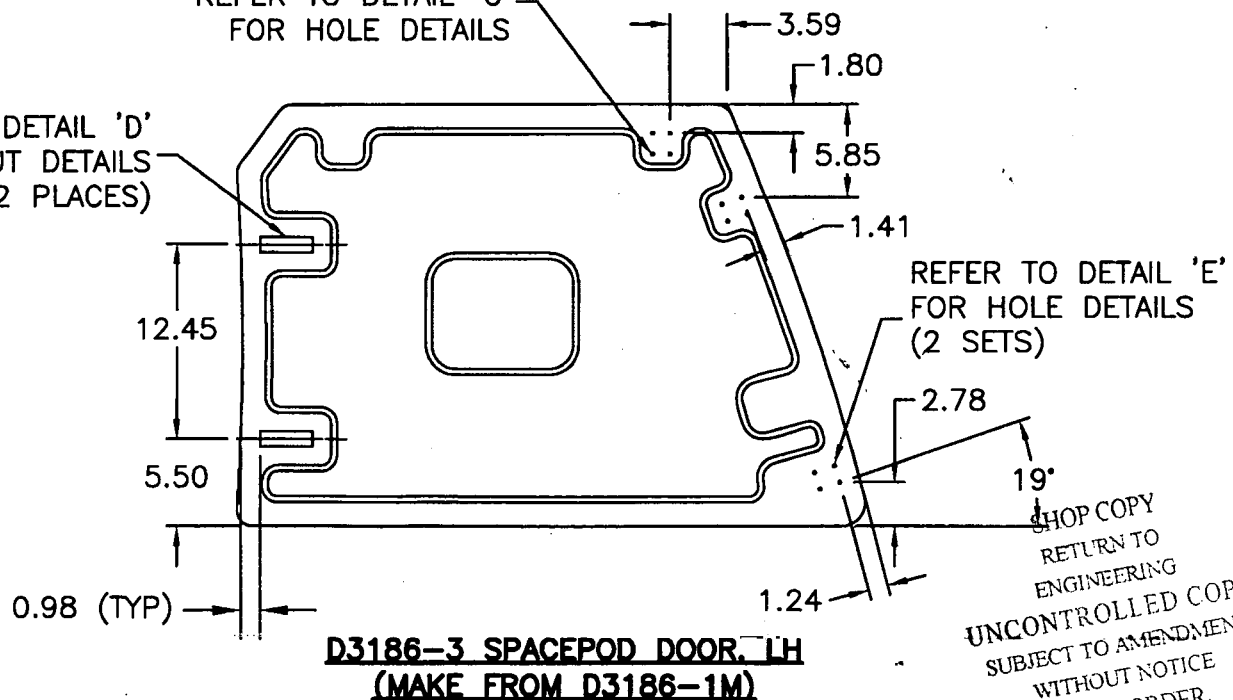
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)

**RELEASED**07.02.27 *[Signature]*

REFER TO DETAIL 'C'  
FOR HOLE DETAILS

REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(2 PLACES)

**NOTES:**

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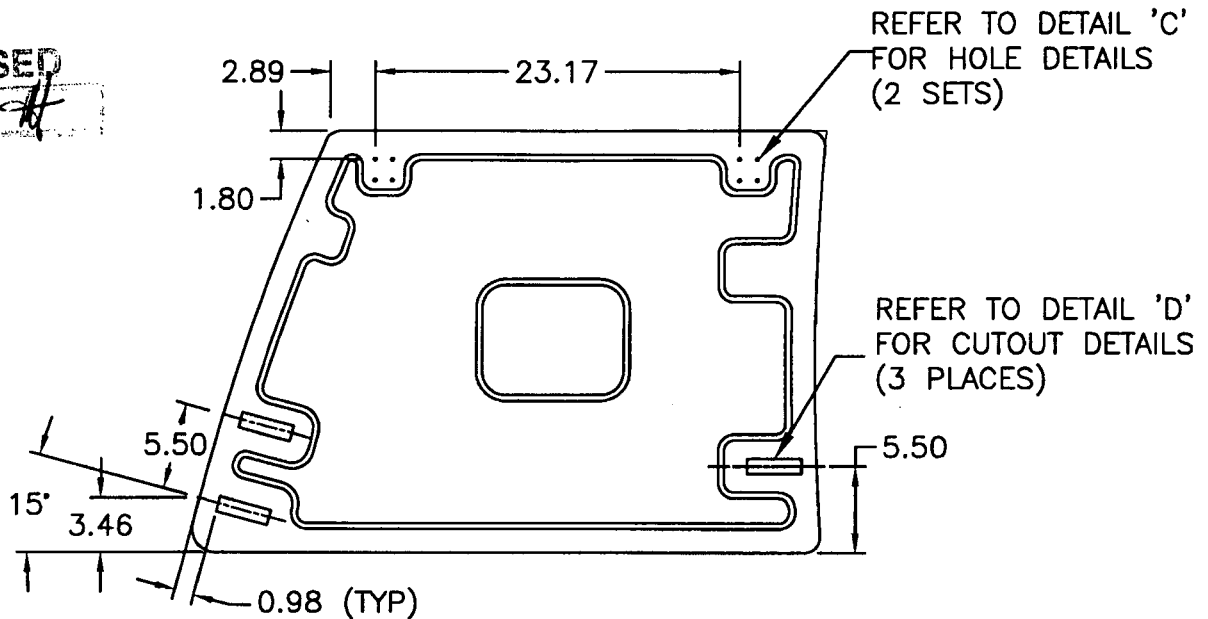
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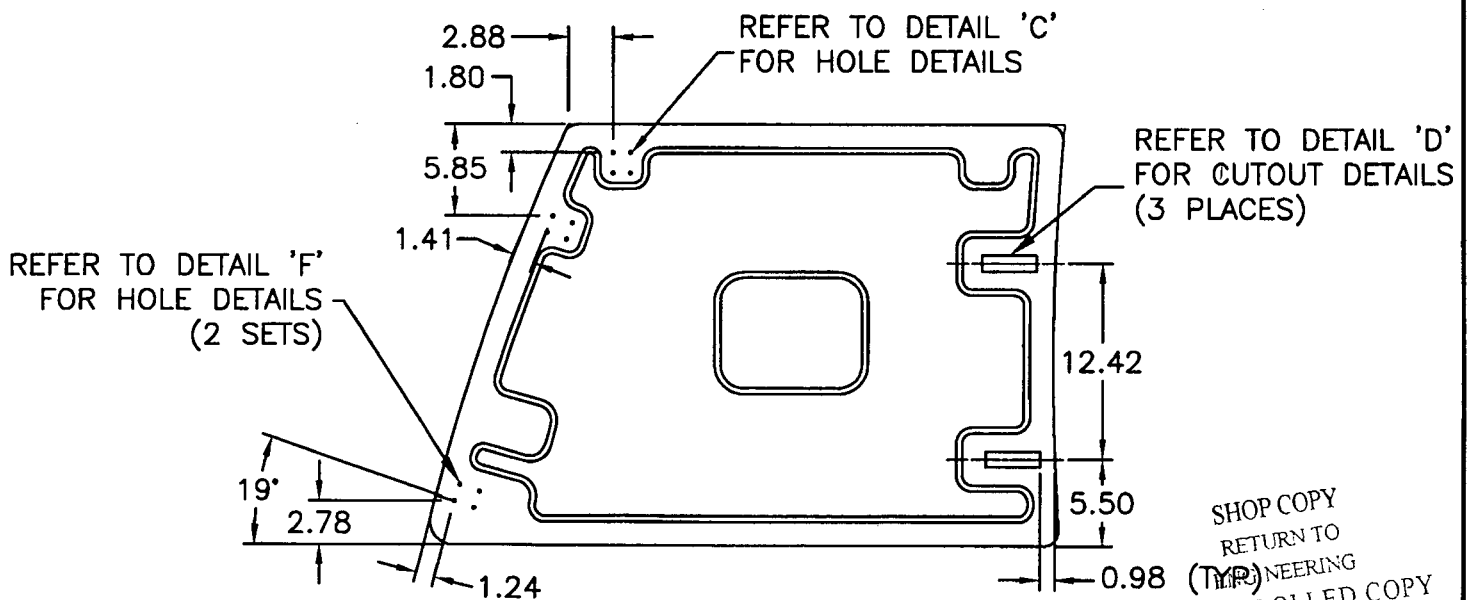
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**RELEASED**

07-02-27



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

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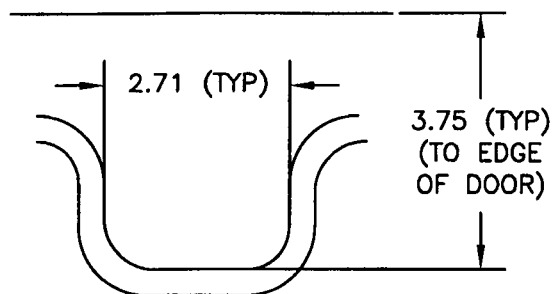
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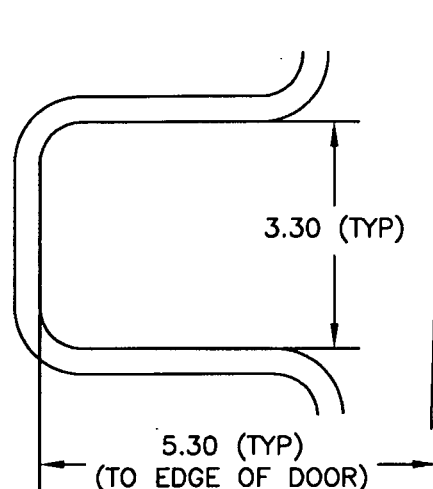
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



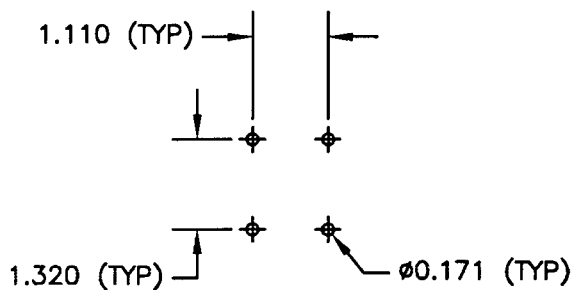
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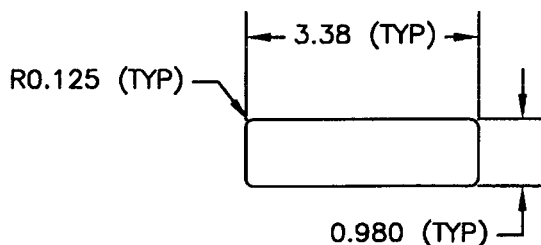
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07.02.27 [Signature]

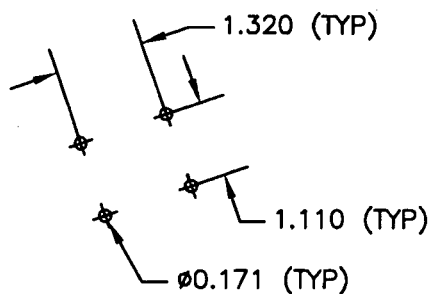


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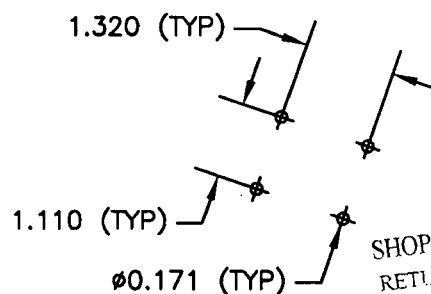


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



**DETAIL F**

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**NOTES:**

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Date: Thursday, 4/12/2007 9:13:49 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 31766C01		
Estimate Number	: 12598		
P.O. Number	:	Part Number	: D31861M
This Issue	: 4/12/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 31082C01	Material	:
Written By	:	Due Date	: 4/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>401.04.13</u>		
Comment	: Est Rev:A New Issue 06-12-04 ec est rev D rv D dwg 07.03.07 ec		

Additional Product

w/o 30010

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: \_\_\_\_\_

Description: D3186-1M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

2.0	D31861P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from  
 Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 . Visual inspection. Check for void spot and pins. Ensure surface of  
 doo is smooth, no dimples for drilling:

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 4/12/2007 9:13:49 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 31766C01

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.06.21



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



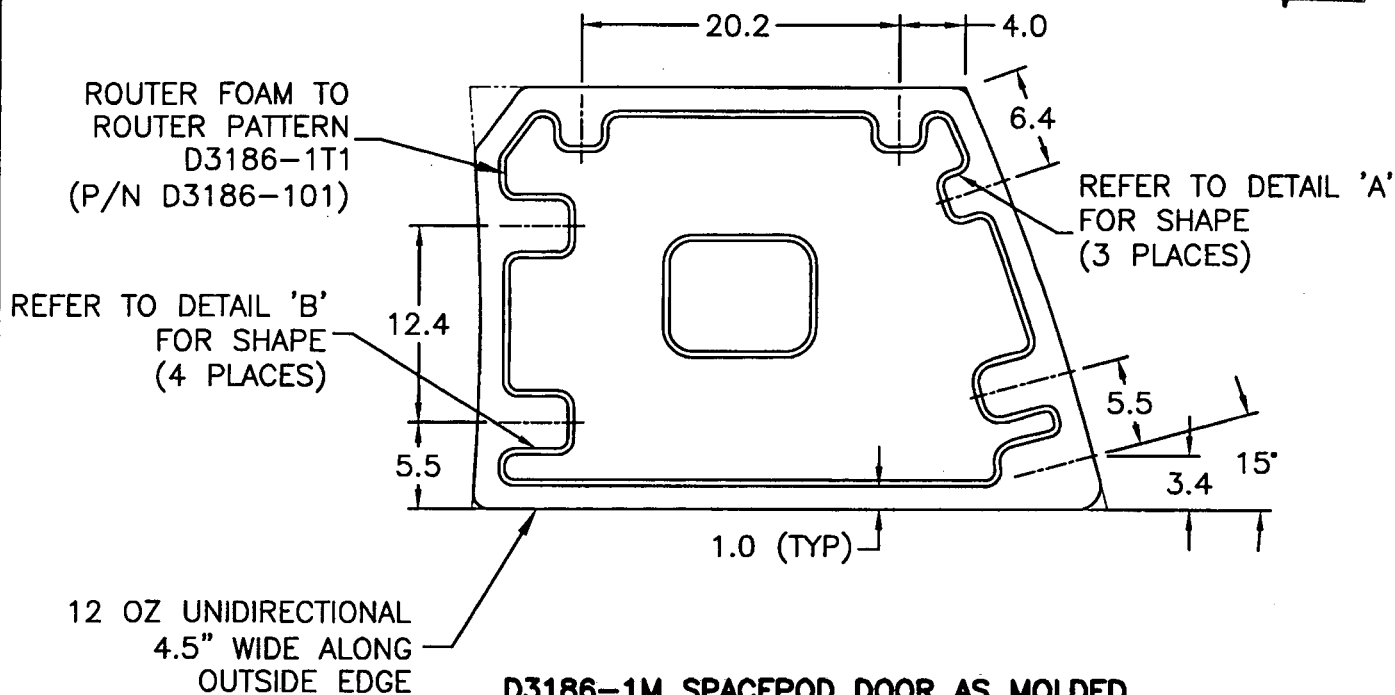
DESIGN DS.	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

#### MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

RELEASED

07.02.27



**D3186-1M SPACEPOD DOOR AS MOLDED**

#### NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**DART**

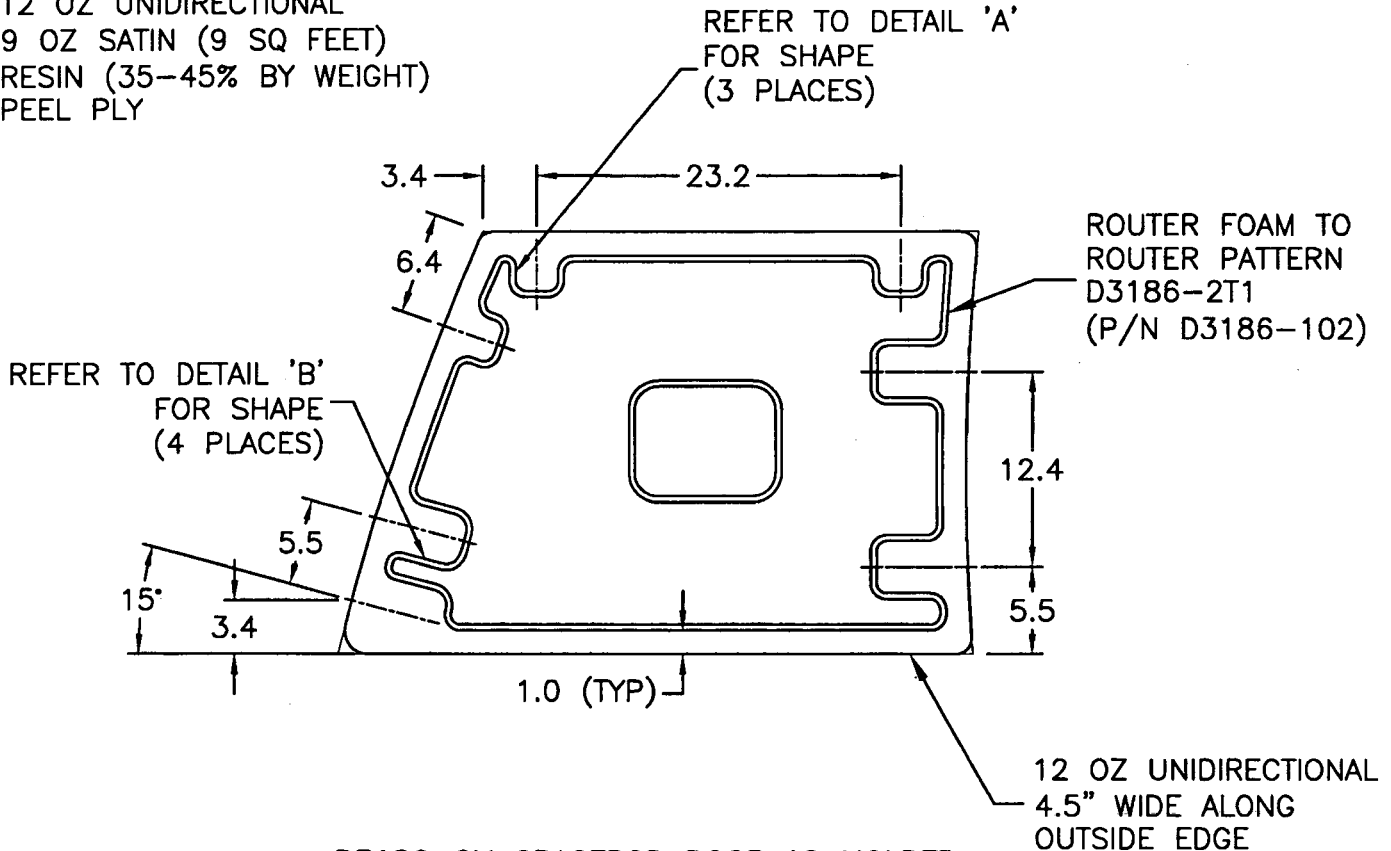
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27 H

**D31P6-2M SPACEPOD DOOR AS MOLDED**NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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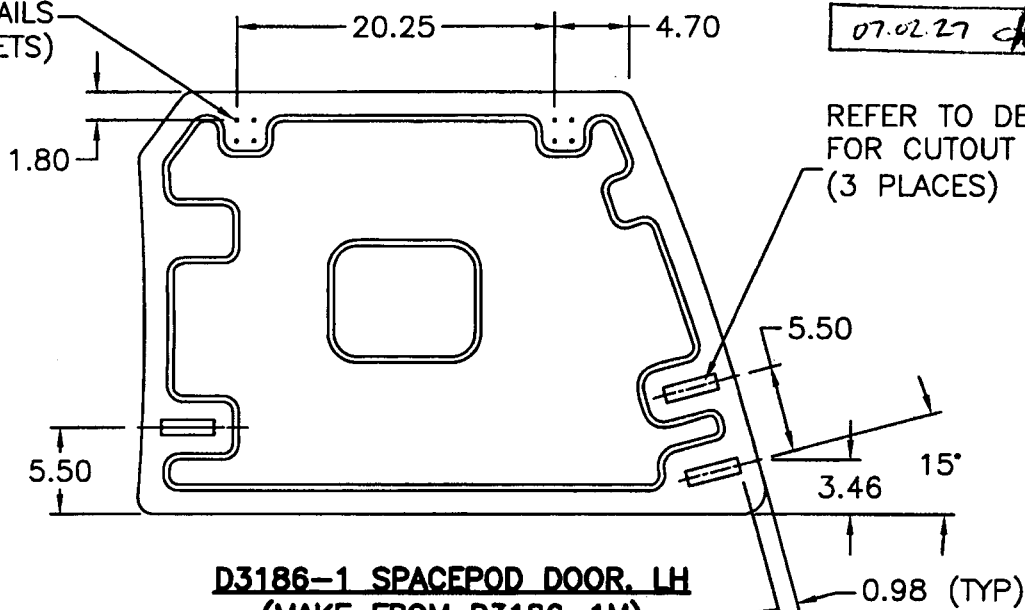
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)

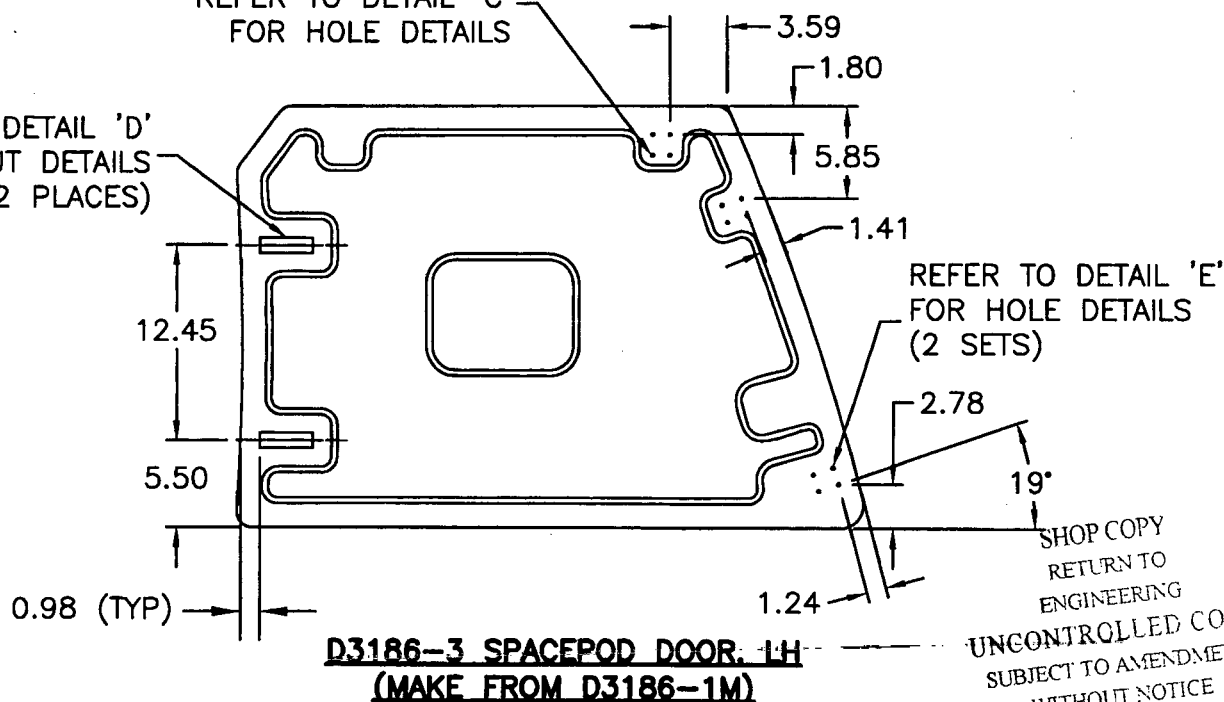
**RELEASED**

07.02.27 [Signature]

REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(3 PLACES)

REFER TO DETAIL 'C'  
FOR HOLE DETAILS

REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(2 PLACES)

**NOTES:**

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- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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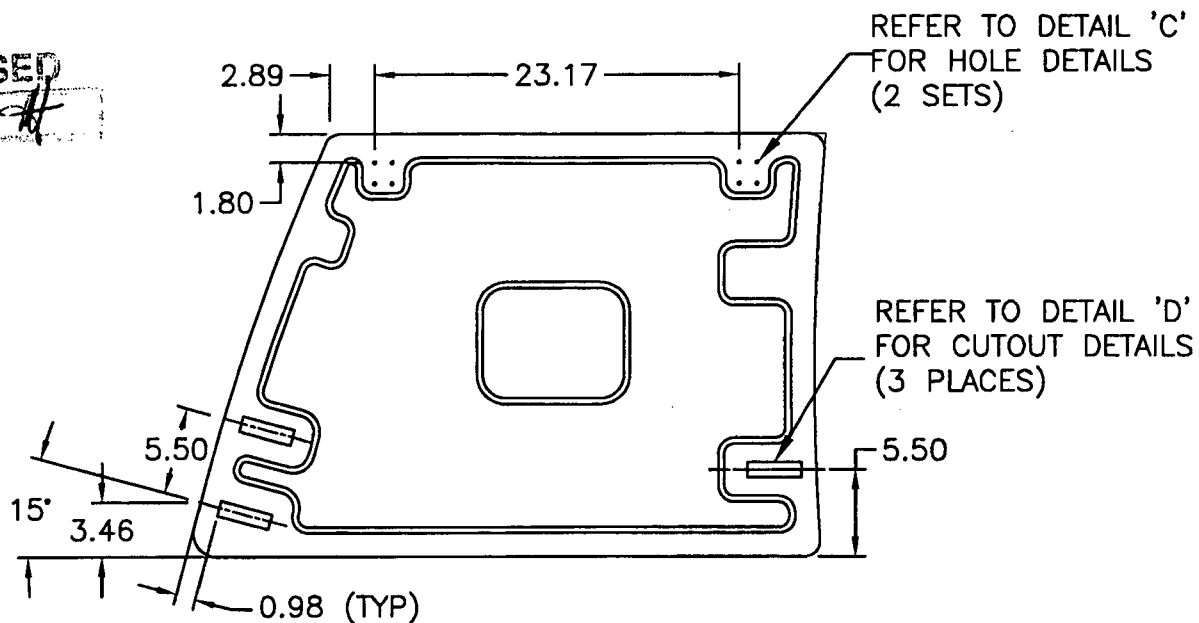
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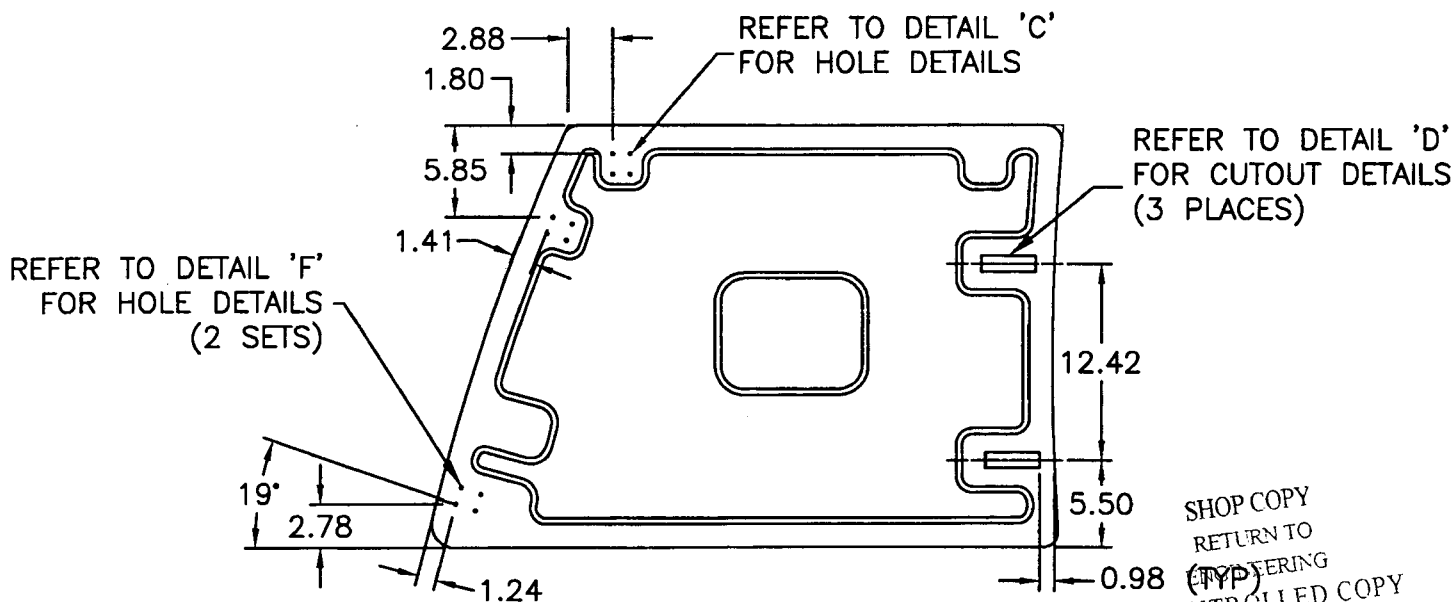
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**RELEASED**

07-02-27



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

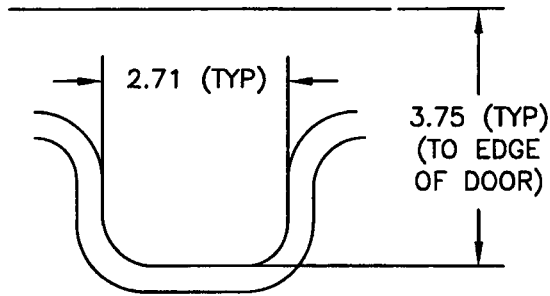
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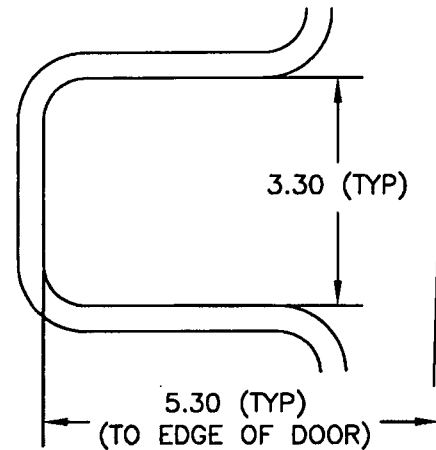
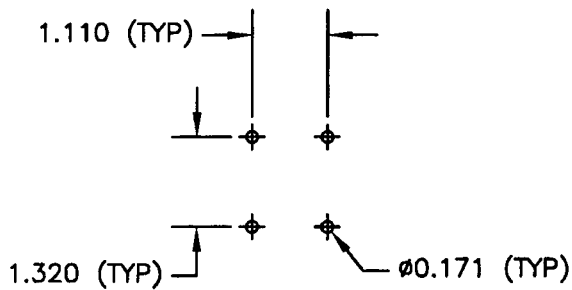
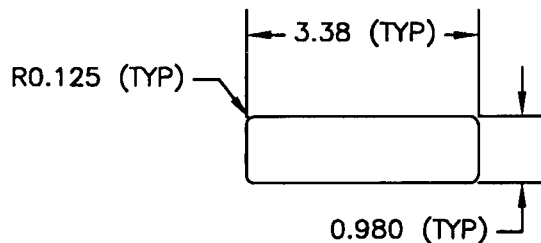
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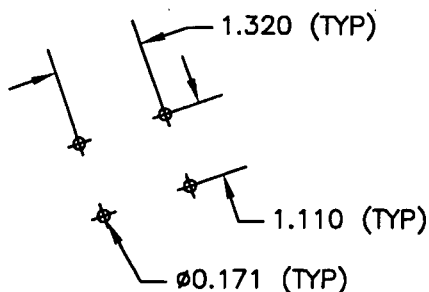
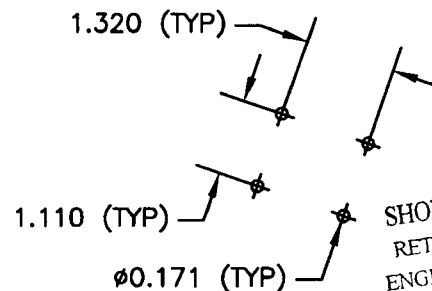
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****RELEASED**

07.02.27 [Signature]

**DETAIL B****DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D****DETAIL E****DETAIL F**

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DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11979
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
04/06/2007	21/12/2006	5092	C. Lavoie		PO00002767		
Order Qty	B.O. Qty	Current Ship.	Item #	Item-Description			
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30010 U de M : Each Dwg. Rév.: D Job: 41319			
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30020 U de M : Each Dwg. Rév.: D Job: 41301			
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30030 U de M : Each Dwg. Rév.: D Job: 41329			
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30040 U de M : Each Dwg. Rév.: D Job: 41310			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Jeudi, 2007-03-29 10:33:48  
Utilisateur: Marc Dubé

## Feuille de Procédé

<b>Client</b> : DART Dart Aerospace Ltd.	<b>Nom Dessin</b> : SPACEPOD DOOR
<b>Numéro Job</b> : 41319	<b>Numéro Article</b> : DKC134-0052
<b>Numéro Soumission</b> : 2584	<b>Numéro Dessin</b> : D3186
<b>Numéro B.A.</b> :	<b>Projet Numéro</b> : DKC134
<b>Cette fois</b> : 2007-03-29 <b>No. B.V.</b> :	<b>Révision dessin</b> : C
<b>Prsht Rev.</b> : NC	<b>Matériel</b> : Fibre 7781 et Résine 411-350
<b>Prem. fois</b> : - - <b>Type</b> :	<b>Date Dûe</b> : 2007-04-05 <b>Qté:</b> 1 <b>UdM:</b> UNITE
<b>Job précédente</b> : 41318	

**Écrit par** : \_\_\_\_\_

**Vérifié & Approuvé par** : \_\_\_\_\_

**Commentaires** : N° de pièce Dart Aerospace : D31861M



Process Sheet Rev.: 01 Modification générale selon informations de l'ingénierie

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------

**Commentair Qty.:** 0.020 GALLON(s)/Unit **Total :** 0.020 GALLON(s)  
Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



**Commentair Setup:** 0.00Hrs/ **Run:** 5.0000Min **Total Run :** 0.0833Hrs  
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

MAY 07 2007

Date:

Heure Début:

8:30

Heure Fin:

11:00

Sceau:



3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

**Commentair Qty.:** 3.28 VERGE(s)/Unit **Total :** 3.28 VERGE(s)  
Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

**Commentair Qty.:** 3.59 VERGE(s)/Unit **Total :** 3.59 VERGE(s)  
Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

**Commentair Qty.:** 3.00 VERGE(s)/Unit **Total :** 3.00 VERGE(s)  
Feutre de drainage N° Airweave N 10

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

**Commentair Qty.:** 3.00 VERGE(s)/Unit **Total :** 3.00 VERGE(s)  
Stretchlon 200 poche à vide Vert



Date: Jeudi, 2007-03-29 10:33:48

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41319

Numéro Article: DKC134-0052

Numéro Job:



# Séq.: Machine ou Opération:

Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentaire Qty.: 4.500 VERGE(s)/Unit Total : 4.500 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

# LOT 1-6083-1

8.0 AC0098

Ruban à gommer jaune #: T/AT-200Y

Commentaire Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s)

Ruban à gommer jaune #: T/AT-200Y

9.0 AAC0443

Fiberglass 12 oz Unidirectional

Commentaire Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-5964-1

10.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe :

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 4/05/07 Heure Début: 8:00 Heure Fin: 10:00



Sceau:

11.0 AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0080 PINTE(s)/Unit Total : 0.0080 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

12.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6133-1

13.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: MAY 10 2007 Heure Début: 1:30 Heure Fin: 1:35



Sceau:

Date: Jeudi, 2007-03-29 10:33:48

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41319

Numéro Article: DKC134-0052

Numéro Job:



# Séq.: Machine ou Opération: Description :

14.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8005 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

MAY 10 2007

Date:

Heure Début:

1:35

Heure Fin:

1:50

Sceau:



15.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

MAY 10 2007

Date:

Heure Début:

1:50

Heure Fin:

2:00

Sceau:



Curing Début:

1:35

Curing Fin:

8:00

16.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)

Catalyst N° DDM-9

N° de Lot:

1-5921-3

17.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6133-1

Date: Jeudi, 2007-03-29 10:33:48

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41319

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
------	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

Date: MAY 10 2007

Heure Début: 8:20

Heure Fin: 8:40

Sceau:



19.0	DKC134-0056	Foam Core N° D3186-101 ( Porte D3186-1 )
------	-------------	--

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-101 ( Porte D3186-1 )

# LOT 1-5826-1

20.0	AAC0452	Polybond B46F
------	---------	---------------

Commentair Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)

Polybond B46F

N° de Lot:

1-6066-1

21.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART
------	--------------	--------------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
ASSEMBLAGE GÉNÉRALE DES PIECES

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0056 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: 17/05/07

Heure Début: 10:30

Heure Fin: 10:50

Sceau:



22.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

1- Tissu à délaminer

2- Feutre de drainage

Date: Jeudi, 2007-03-29 10:33:48

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41319

Numéro Article: DKC134-0052

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation ( entre 1 heure et 1heure 1/2 ) afin d'enlever le surplus de polybond.

Date: 17/05/07 Heure Début: 10:50 Heure Fin: 11:00 Sceau:



Curing Début: 10:30 Curing Fin: 11:50

23.0 AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

24.0 AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6183-1

25.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 18/05/07 Heure Début: 10:15 Heure Fin: 10:20 Sceau:



26.0 LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Faire le liminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte .

Faire le laminage du dernier pli de 9.7 oz.

Date: 18/05/07 Heure Début: 10:20 Heure Fin: 11:00 Sceau:



Date: Jeudi, 2007-03-29 10:33:49

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41319

Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

27.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 18/05/07 Heure Début: 11:00 Heure Fin: 11:20 Sceau: 



Curing Début: 10:20 Curing Fin: 8:00


28.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
DÉMOULAGE DES PIECES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule pour éliminer le fini lisse de celui-ci


Date: 18/05/07 Heure Début: 4:15 Heure Fin: 4:30 Sceau: 

29.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TRIMAGE DE FINITION

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 22/05/07 Heure Début: 8:00 Heure Fin: 8:30 Sceau: 

30.0	AAC0671	Dupont Primer N° 1104S
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Commentair Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)  
Dupont Primer N° 1104S 1-6065-2

Date: Jeudi, 2007-03-29 10:33:49

Utilisateur: Marc Dubé

## Feuille de Procédé

\*Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41319

Numéro Article: DKC134-0052

Numéro Job:



# Séq.: Machine ou Opération: Description :

31.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)

Dupont Activator N° 7975S

1-6065-1

32.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)

Dupont Reducer N° 12375S

1-5092-2

33.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PRÉPARATION DU MATÉRIEL DART

Nettoyages Qty 1 22-05-07

MAY 22 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

34.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PEINTURE / PRIMER DART

Appliquer la première couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) selon I.G. #  
Application du primer.

Laisser sécher pendant 3 heures.

MAY 22 2007

Date: Heure Début: Heure Fin: Sceau:



35.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

FINITION PIÈCE DART

Sabler la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfections et enlever le lustre du primer.

36.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

Date: Jeudi, 2007-03-29 10:33:49

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41319

Numéro Article: DKC134-0052

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

37.0 AAC0646 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.050 KIT(s)/Unit Total : 0.050 KIT(s)  
MASTIC POLYSTOP SIKKENS 3AR591

38.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens N° de Lot: 1-6079-1

39.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de sikkens.

Date: 23-5-07 Heure Début: 1:40 Heure Fin: 3:50 Sceau:

*Remwork*  
29-5-07



40.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-6065-2

41.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)  
Dupont Activator N° 7975S N° de Lot: 1-6065-1

42.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: 1-5092-2

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

MAY 23 2007

MAY 29 2007



*Nettoyages Qty 1*  
29-05-07

*Remwork*

*Rawak*



44.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  
APPLICATION DE PRIMER

Appliquer la deuxième couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G. #  
Application du primer

Date: MAY 23 2007 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:

MAY 29 2007



*Remwork*

Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41319

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0052

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

45.0

INSPECTION 3

INSPECTION PIÈCE DART



1 RÉPARATION RNC: C1260



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
INSPECTION PIÈCE DART

OK

INSPECTE 31-5-07



Emballage QT 1

31 mai 07

